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(54) **Wound care device**

(57) The invention relates to wound care devices having a topically applied silver-based antimicrobial finish. More specifically, this disclosure relates to a wound care device having a substrate selected from the group consisting of fibers, fabrics, and alginates, at least a portion of said substrate being coated with a non-electrically

conductive finish, wherein said finish comprises at least one silver ion-releasing compound and at least one binding agent, and wherein said silver ion-releasing compound is present in an amount that is at least 35% more than the amount of said binding agent.

EP 2 589 393 A2

Description**TECHNICAL FIELD**

5 **[0001]** This disclosure relates to wound care devices, which may have a topically applied silver-based antimicrobial finish. More specifically, this disclosure relates to topical antimicrobial finishes with silver ion-releasing mechanisms and to articles having these antimicrobial finishes. The application of the present finish to a substrate results in an antimicrobial product that substantially retains its initial color. This highly desirable feature contrasts sharply with products that are commercially available today and that may be described in the prior art, which are silver-based antimicrobial articles that typically appear as dark colored substrates.

10 **[0002]** The present finish may be applied to a target substrate to provide a single layer antimicrobial wound care device. Alternatively, a silver-containing layer, as will be described herein, may be combined with one or more additional layers to provide a composite antimicrobial wound care device.

15 **[0003]** In one potentially preferred embodiment, a silver-based antimicrobial finish is topically applied to a fabric comprised of fibers. Such fibrous substrates provide sufficient surface area onto which the silver ion-releasing antimicrobial may adhere, thus making available an amount of surface-available silver on the wound care device that is sufficient for promotion of wound healing.

20 **[0004]** In yet another potentially preferred embodiment, a wound care device is disclosed which contains one-way capillary force "pumps" that are capable of transporting fluid, such as wound exudate, away from a wound site to the opposite side of the wound care device, which functions as a segregated fluid reservoir. This fluid transport mechanism generally aids in reducing wound maceration by removing excess wound fluid and, consequently, the protease enzymes and infectious bacteria contained within the wound fluid. The wound care device performs this function, often for multiple consecutive days, without a loss in the physical integrity of the wound care device. In addition to providing a uni-directional fluid transport mechanism, the wound care device may contain a topically applied silver-based antimicrobial finish which provides certain levels of antimicrobial agent to the wound in order to reduce infection from the wound site and control microbial growth in the wound care dressing. Exemplary topical antimicrobial finishes include silver ion-releasing compounds.

25 **[0005]** The wound care device may be comprised of a knit construction characterized in that polyester fiber is primarily present on the wound contact surface and nylon fiber is primarily present on the fluid reservoir surface. A third fiber, such as an elastomeric polyurethane known by the tradename LYCRA®, may also be included in order to provide some amount of elasticity to the wound care device. The wound care device provides a uni-directional flow of fluid away from the wound and into the nylon fluid reservoir. Since the fluid is partitioned away from the wound, the propensity of localized wound maceration is reduced. Furthermore, due to the construction of the wound care device, at least in part, the device maintains a high degree of physical integrity when saturated with fluid.

30 **[0006]** In whatever form (that is, single layer or composite) and being made from whatever materials (natural or synthetic), the present wound care device substrate is unique in that it substantially retains its original color through processing, irradiation, and storage, compared to similar articles produced from other silver-based compounds present at the levels required for effective wound treatment. Further, the ability to create essentially white-colored, silver-based antimicrobial textiles, which are capable of moisture management, affords the opportunity to provide silver-based antimicrobial substrates in a wide variety of light colors previously unavailable.

BACKGROUND

35 **[0007]** Silver-containing antimicrobials have been incorporated into wound care devices and are rapidly gaining acceptance in the medical industry as a safe and effective means of controlling microbial growth in the wound bed, often resulting in improved healing. It is known that placing surface-available silver in contact with a wound allows the silver to enter the wound and become absorbed by undesirable bacteria and fungi that grow and prosper in the warm, moist environment of the wound site. Once absorbed, the silver ions kill microbes, resulting in treatment of infected wounds or the prevention of infection in at-risk wounds.

40 **[0008]** However, existing wound care devices with active silver components typically have two major shortcomings. First, the presence of silver tends to cause discoloration of the substrate into which the silver is incorporated. A second problem with existing devices is that their construction fails to provide adequate movement, or transport, of moisture (such as wound exudate) away from the wound site. The device of the present disclosure addresses and overcomes these deficiencies.

45 **[0009]** Discoloration of substrates containing silver ion-releasing compounds is known to occur. Silver ion-releasing compounds, such as those selected from the group consisting of silver ion exchange materials (e.g. zirconium phosphates and zeolites), silver particles (e.g. silver metal, nanosilver, colloidal silver), silver salts (e.g. AgCl, Ag₂CO₃), silver glass, and mixtures thereof, are generally susceptible to discoloration and have a tendency to alter the color of the substrate

in which they are incorporated. More specifically, excess silver ions can combine with available anions to form colored, precipitated salts. Many of these silver salts darken upon exposure to light as a result of the photo-reduction of silver ion to silver metal. When such compounds are incorporated into prior wound care devices at levels required to deliver effective performance, the color of the substrate is darkened as a result of the presence of the silver compounds.

[0010] This dark color of the substrate is especially problematic in the medical industry, and specifically in wound care devices, where examination of the wound site (as well as the bandage or dressing covering the wound) can provide important indicators of the effectiveness of the treatment administered to a particular wound. As such, evidence of color on the wound care device may indicate infection at a wound site (e.g., purulent green discharge being indicative of infection with a *Pseudomonas* species of bacteria), uncontrolled bleeding (e.g., red discharge), or debrided eschar (e.g., brown slough), with such discoloration being more readily apparent in a white, or similarly light-colored, wound care device.

[0011] However, if the device has a dark color as manufactured due to a high loading of silver antimicrobial contained within or on the wound care device itself, the relevant color (e.g., from blood or infected exudates) during use may be more difficult for the caregiver to assess. Thus, it is important to those in the medical industry that the wound care device itself does not become discolored merely because silver ions are undergoing photo-reduction, as such discoloration could lead to confusion as to the effectiveness of the treatment being administered to the wound. Accordingly, a stable silver-containing antimicrobial finish on a wound care device, which substantially maintains the original color of the device, is most desirable.

[0012] There have been various attempts by others to create silver ion-releasing wound care devices. In many wound care devices, the silver antimicrobial is present throughout the entire cross section of the device. For example, silver antimicrobials have been adapted for incorporation within melt-spun synthetic fibers in order to provide certain fabrics that selectively and inherently exhibit antimicrobial characteristics. Commercial examples include DAK's antimicrobial polyester fiber under the tradename STERIPURE® and Unifi's antimicrobial nylon fiber under the tradename A.M.Y. In another example, silver antimicrobials have been adapted for incorporation within bi-component, core/sheath fibers as taught within US Patent Nos. 6,723,428 and 6,841,244.

[0013] However, the melt-spun fibers described above are expensive to produce due to the large amount of silver-based compound required to provide sufficient antimicrobial activity, especially in light of the relative lack of migration of the compound from within the fiber itself to its surface. As such, when these silver-containing fibers are combined to form a wound care device, the silver located on the interior of the fiber may never reach the wound site during the useful life of the device to provide any advantage to the healing process. Thus, this approach results in an inefficient and expensive use of silver in wound care devices, and it is even likely that the amount of silver released from the fibers is inadequate for promoting the healing process.

[0014] Others have attempted to provide composite, multi-layered wound care devices. An example of this approach is marketed by Smith and Nephew under the tradename ACTICOAT®. This wound care device is comprised of three layers—a layer of polyethylene film, a middle layer of rayon/polyester blend nonwoven fabric, and a second layer of film. Nano-crystalline silver particles are deposited onto the film layers to provide an antimicrobial wound care device. However, this technology generally fails to impart desirable release of silver from the device, while the device itself exhibits a metallic blue coloration. This product has the potential to initially release large amounts of silver from the wound care device, often in the form of silver flakes, which may enter the wound bed and may lead to irritation of the wound.

[0015] Another product available to consumers, provided by Johnson & Johnson under the trademark ACTISORB®, is a highly porous, silver-impregnated charcoal cloth, sandwiched between two nylon nonwoven layers. This product generally provides very low release of silver, and the device itself is black initially due to the presence of a silver charcoal active ingredient.

[0016] Yet another example is manufactured by Argentum under the trademark SILVERLON®. Silver, via a solution of silver nitrate, is reduced and deposited on sensitized polymeric fibers (typically nylon). The silver-laden polyamide is then attached to a subsequent fiber layer. Because of the nature of this technology, it is difficult to control the amount of silver deposited on the substrate, causing this product to show dark coloration as well.

[0017] In all cases where the wound care device is colored (e.g., metallic blue, brown, gray, black) by the addition of silver to the device, a situation exists in which medical personnel and/or the users thereof will have greater difficulty in caring for wound sites and monitoring the healing process. To this point, attempts to create a fiber-based wound care device having both effective antimicrobial properties and its original color (preferably white) have been unsuccessful.

[0018] Because treatments in which the silver antimicrobial is incorporated into the fiber have been found ineffective, another approach was necessary. A topical finish for textile substrates, such as a fabric, is desirable because it permits treatment of a fabric's individual fibers before or after weaving, knitting, and the like, in order to provide greater functionality to the target yarn and enhanced likelihood of effectiveness in a wound care device. Such a finish should be capable of releasing a desired amount of silver to the wound from a substrate whose color has not been substantially altered by the addition of a silver antimicrobial. Furthermore, it is desirable in the case of metallic silver that a metallized treatment be electrically non-conductive on the target fabric, fiber, or yarn.

[0019] Methods of topically applying a silver-based antimicrobial finish to textile substrates are described in commonly

assigned U.S. Patent Nos. 6,584,668; 6,821,936; and 6,946,433 and in commonly assigned U.S. Patent Application Serial Nos. 09/586,081; 09/589,179; 10/307,027, and 10/306,968. Details of many of these processes will be discussed below.

[0020] The present disclosure addresses and overcomes the problems of discoloration associated with silver-containing wound care devices described above. Whereas, historically, a silver antimicrobial has been incorporated into a melt or polymer matrix prior to the formation of a fiber or substrate, or silver metal is deposited on the surface to create a dark-colored antimicrobial substrate useful for wound care devices, the present disclosure describes a method for achieving an effective wound care device having a silver-based antimicrobial finish, which is topically applied to a target substrate without substantially altering the color of the device. The resultant wound care device provides desired release of silver to the wound site and, because of its unchanged color, offers benefits in terms of wound monitoring and manufacturing flexibility.

[0021] Thus, a silver-releasing wound care device having an L* value of at least about 68.0 (indicative of fabric lightness, as will be discussed herein) is useful in monitoring the treatment of a wound site, where the use of the device includes the steps of providing the present wound care device, applying the wound care device to the wound site, and monitoring the various stages of healing at the wound site (for example, as evidenced by changes in the type and amount of wound fluid on the wound care device).

[0022] In the medical field, and in the area of wound care particularly, it is well-established that many factors, including the amount of moisture present at a wound site, affects how quickly a wound will heal. Generally speaking, having an excessive amount of moisture present at a wound site, especially when combined with the warm environment provided by the body, leads to undesirable bacteria growth and production of protease enzymes in the wound. Such growth can cause further damage to healthy cells and delay the healing process. However, insufficient moisture at the wound site can cause eschar (scab) formation and scarring and may cause the wound care device, or medical dressing, to adhere to the wound. If the dressing adheres to the wound, subsequent removal of the dressing may cause undue discomfort to the patient as well as disrupt newly granulated tissue. Infection of the wound may also be compounded when a medical dressing is removed and portions of the dressing remain behind in the wound itself, particularly if the dressing is already colonized with pathogenic microbes. Thus, it is important that the dressing maintains its physical integrity when exposed to stress, such as during removal from the wound, in order to prevent additional complications and delays in healing.

[0023] Absorptive materials such as gauzes, hydrogels, swellable fibers, foams, woven textiles and the like have been incorporated into wound care devices for the purpose of controlling the wound moisture content. Fluids are generally absorbed by these types of materials by reversible capillary action or osmosis rather than by a one-way directional flow created by an inventive two-sided wound care device.

[0024] For example, US Patent No. 5,009,652 to Morgan et al. discloses a disposable laminated medical sponge that contains a thin film which is impervious to fluids and infectious agents. The medical sponge is designed to prevent the seepage of bodily fluids from one side of the sponge to the opposite side, since such seepage provides risk of infection for health-care workers having direct contact with patients.

[0025] US Patent No. 6,194,332 to Rock et al. discloses an antimicrobial composite fabric having a first inner fabric layer and a second outer fabric layer. The inner fabric layer may be comprised of polyester, acrylic or nylon fiber which has been rendered hydrophilic, such as by mechanical or chemical treatment. The hydrophilic inner fabric layer enables the transport of sweat from the inner fabric layer to the outer fabric layer. The fibers in the outer layer of the fabric may be blended with antimicrobial fibers in order to reduce the proliferation of bacteria in this layer. The fabric may be formed into a garment which provides reduced body odor. US Patent No. 6,602,811 to Rock et al. discloses a similar antimicrobial composite fabric, except that the second outer fabric layer also may be treated with an antimicrobial paste.

[0026] US Patent Application Publication No. 2004/0001880 to Bowler et al. discloses the use of gel forming fibers such as sodium carboxymethylcellulose which can be incorporated into wound dressings. Silver ions may be incorporated into the fibers by combining them in a solution with a solvent prior to fiber formation. The dressing may be used as part of a larger dressing or a layer in a multi-layered dressing and need not be in direct contact with the wound.

[0027] The wound care device of the present invention takes advantage of a unique textile fabric construction which effectively isolates fluid away from the wound, which often results in improved healing. The differentiation that exists in a wound care device having a hydrophobic fiber on the wound contact side of the device and hydrophilic fiber on the fluid reservoir side of the device creates a unique one-way, directional flow of fluid and contaminants away from the wound.

[0028] The present disclosure addresses and overcomes the problems associated with moisture management described above. Whereas, historically, a gauze or foam medical dressing has been applied to a wound with at least some intent on absorbing fluids, the present disclosure describes a wound care device capable of creating a one-way, directional flow of fluid and contaminants away from the wound, without detrimentally causing excessive dryness of the wound and substantial adherence of the device to the wound. The wound care device may additionally provide desired release of silver to the wound site for antimicrobial efficacy and, because of its unique construction, maintains its physical integrity when exposed to stress during ordinary use of the wound care device.

[0029] Thus, a wound care device for managing the movement of wound fluid from a wound site to the wound care

device, where the wound care device has a wound contact surface and a wound fluid reservoir surface opposite the wound contact surface, is useful in monitoring the treatment of a wound site, where the use of the device includes the steps of providing the present wound care device, applying the wound care device to the wound site such that the wound contact surface is contiguous with the wound site, and monitoring the movement of wound fluid by uni-directionally transporting the wound fluid through the wound contact surface of the device to the wound fluid reservoir surface of the device. If desired, a finish containing a silver ion-releasing compound may further be added to the wound care device.

[0030] The present wound care device optionally includes additional layers that may assist in boosting absorption capacity, such as, for example, one or more layers of cotton gauze, foam, alginate, carboxymethyl cellulose, and the like. These additional layers may or may not contain an antimicrobial agent.

[0031] For these reasons and others that will be described herein, the present effective silver wound care device represents a useful advance over the prior art.

BRIEF DESCRIPTION OF THE DRAWINGS

[0032] **FIGURE 1** is a line graph depicting the reflectance of **Examples 2A, 3A, 4A, 5B**, and **Comparative Examples A-E**.

DETAILED DESCRIPTION

[0033] The wound care device of the present invention is generally intended to be used for treatment of various wounds including, without limitation, partial thickness burns, incisions, skin grafts, donor sites, lacerations, abrasions, Stage I-IV pressure ulcers, vascular venous stasis, and diabetic ulcers.

Definitions and Terms

[0034] "Hydrophilic" is defined as having a strong affinity for or the ability to absorb water.

[0035] "Hydrophobic" is defined as lacking affinity for or the ability to absorb water.

[0036] "Non-electrically conductive" is defined as having a resistance in ohms per square inch of fabric of greater than about 10,000 ohms, preferably greater than about 100,000 ohms and most preferably greater than about 1×10^9 ohms, when measured in accordance with AATCC Test Method 76-1978.

Wound Care Substrates

[0037] Suitable substrates for receiving a topically applied silver-based antimicrobial finish include, without limitation, fibers, fabrics, and alginates. The fabric may be formed from fibers such as synthetic fibers, natural fibers, or combinations thereof. Synthetic fibers include, for example, polyester, acrylic, polyamide, polyolefin, polyaramid, polyurethane, regenerated cellulose (i.e., rayon), and blends thereof.

[0038] The term "polyamide" is intended to describe any long-chain polymer having recurring amide groups ($--NH-CO--$) as an integral part of the polymer chain. Examples of polyamides include nylon 6; nylon 6, 6; nylon 1, 1; and nylon 6, 10.

[0039] The term "polyester" is intended to describe any long-chain polymer having recurring ester groups ($--C(O)-O--$). Examples of polyesters include aromatic polyesters, such as polyethylene terephthalate (PET), polybutylene terephthalate (PBT), poly trimethylene terephthalate (PTT), and polytriphenylene terephthalate, and aliphatic polyesters, such as polylactic acid (PLA).

[0040] "Polyolefin" includes, for example, polypropylene, polyethylene, and combinations thereof. "Polyaramid" includes, for example, poly-*p*-phenyleneterephthalamid (i.e., KEVLAR®), poly-*m*-phenyleneterephthalamid (i.e., NOMEX®), and combinations thereof. Natural fibers include, for example, wool, cotton, flax, and blends thereof.

[0041] The fabric may be formed from fibers or yarns of any size, including microdenier fibers and yarns (fibers or yarns having less than one denier per filament). The fibers or yarns may have deniers that range from less than about 1 denier per filament to about 2000 denier per filament or more preferably, from less than about 1 denier per filament to about 500 denier per filament, or even more preferably, from less than about 1 denier per filament to about 300 denier per filament.

[0042] Furthermore, the fabric may be partially or wholly comprised of multi-component or bi-component fibers or yarns, which may be splittable, or which have been partially or fully split, along their length by chemical or mechanical action. The fabric may be comprised of fibers such as staple fiber, filament fiber, spun fiber, or combinations thereof.

[0043] The fabric may be of any variety, including but not limited to, woven fabric, knitted fabric, nonwoven fabric, or combinations thereof. The unique and interesting achievement realized through the present topical application is that the wound care device substantially maintains its original color, despite the presence of effective amounts of a silver-based

antimicrobial agent. The elimination of color normally associated with the inclusion of silver-based antimicrobials is highly beneficial and desirable. The wound care devices (preferably, white-colored), as will be described herein, allow users thereof and their health care providers to monitor the exudates from the wound. Further, the present wound care devices exhibit long-term color stability (that is, their color does not change significantly over time while in production, transit, or storage). Finally, because the present wound care device is not discolored by the addition of the silver-based antimicrobial agent, a variety of substrate colors may be utilized or the finished wound care devices may be dyed or colored to any desired shade or hue with any type of colorant, such as, for example, pigments, dyes, tints, and the like.

[0044] For instance, the fabric used for the present wound care device may optionally be colored by a variety of dyeing techniques, such as high temperature jet dyeing with disperse dyes, vat dyeing, thermosol dyeing, pad dyeing, flexographic printing, transfer printing, screen printing, or any other technique that is common in the art for comparable textile products. If yarns or fibers are treated by the process of the current invention, they may be dyed by suitable methods prior to fabric formation, such as, for instance, by package dyeing or solution dyeing, or after fabric formation as described above, or they may be left undyed.

[0045] Other additives may be present on and/or within the target fabric or fiber, including antistatic agents, optical brightening compounds, opacifiers (such as titanium dioxide), nucleating agents, antioxidants, UV stabilizers, fillers, permanent press finishes, softeners, lubricants, curing accelerators, adhesives, odor control agents, molecular scavengers (such as compounds to bind endotoxins), and the like. The present fabrics may also be coated or printed or otherwise aesthetically modified in addition to being treated with the present antimicrobial compositions.

[0046] However, it should be noted that additives such as optical brightening compounds, opacifiers, dyes, and pigments are not required on or within the target substrate in order to achieve a white wound care device. These specific additives may be included merely for the purpose of enhancing the whiteness already exhibited by the wound care device.

[0047] Alginates from commercial sources are an alternative substrate, which may be used in place of fabrics. A typical process of manufacturing alginates involves crushing and washing of the raw material (i.e., seaweed) and dissolution of the extracted sodium alginate in water. A viscous solution is obtained that is extruded into a calcium chloride bath. Here, the sodium ions are replaced by calcium ions, and an insoluble calcium alginate is precipitated. Rinsing and dehydration then leads to the production of a fiber. Fibers may be formed from alginate by extruding or spinning the alginate from an aqueous solution. The fibers are then typically laid down in a web mat that can be incorporated into a wound care device.

[0048] An alginate web containing the calcium alginate fibers is placed on the wound in a dry state and begins to absorb the exudates. At this time, reverse ion exchange takes place, in which the calcium ions that are present in the alginate are gradually exchanged for sodium ions that are present in the blood and wound exudates. The fibers absorb large amounts of secretions, start to swell, and, in the presence of sodium ions, turn into a moist gel that fills and securely covers the wound.

[0049] In one embodiment of the invention, a commercially available nonwoven fabric is used to form the wound care device. Nonwovens are known in the textile industry as an alternative to traditional woven or knit fabrics. To create a nonwoven fabric, a filament web must be created and then consolidated. In one method, staple fibers are formed into a web through the carding process, which can occur in either wet or dry conditions. Alternatively, continuous filaments, which are formed by extrusion, may be used in the formation of the web. The web is then consolidated, and/or bonded, by means of needle-punching, thermal bonding, chemical bonding, or hydroentanglement. A second consolidation method may also be employed such as thermal bonding.

[0050] One potentially preferred substrate for use in the wound care device of the present disclosure is a nonwoven fabric formed of continuous splittable filaments that are extruded as a web and then consolidated. This nonwoven fabric is described in U.S. Patent Nos. 5,899,785 and 5,970,583, both assigned to Firma Carl Freudenberg of Weinheim, Germany. Preferably, the nonwoven web is consolidated through hydroentanglement, and, more preferably, through hydroentanglement followed by thermal, or point, bonding. The continuous composite filaments are obtained by means of a controlled spinning process, and the hydroentanglement process mechanically splits at least some, if not most, of the composite filaments into their elementary components. This structure of split fibers provides a greater surface area onto which the present silver-based antimicrobial compound may be applied and, therefore, greater amounts of surface-available silver that may contact the wound.

[0051] One specific example of a knit pattern that is suitable for making the fabric that comprises one embodiment of the wound care device of the present invention is a jersey knit. A jersey knit is a circular or flat-knit fabric made with a plain stitch in which the loops intermesh in only one direction. As a result, the appearance of the face and the back of the jersey fabric is wholly different. Thus, by utilizing a jersey knit to form a fabric comprised of polyester, nylon, and elastomeric fibers, a fabric may be constructed that is primarily polyester-containing on one side while the opposite side of the fabric is primarily nylon-containing. The elastomeric fiber provides some level of stretch to the fabric, which may be useful for some wounds that require, for example, a dressing to be wrapped snugly around the wound site. The elastomeric fiber, in addition to providing conformability to the wound care device, also provides some level of softness to the device. Spandex is one non-limiting example of an elastomeric fiber and may be known by the tradename LYCRA®,

which is available from INVISTA of Wichita, Kansas.

[0052] Additionally, it may be generally known to those skilled in the art that a knit polyester fabric tends to be hydrophobic, slow to absorb liquids, and generally exhibits little or no wicking of moisture. Since polyester is hydrophobic in nature, conventional wisdom would lead one to choose a hydrophilic natural fiber, such as cotton, or a hydrophilic synthetic fiber, such as nylon, as the wound contacting side of the wound care device. However, it was unexpectedly discovered that by placing a hydrophobic polyester containing surface against the wound site and a hydrophilic nylon containing surface away from the wound site, a unique one-way, directional flow of fluid away from the wound site was achieved.

[0053] The wound care device may be of any thickness, depending on the construction of the fabric. It may, however, be preferred that the thickness of the wound care device is between about 25 and about 60 mils. It may be more preferred that the wound care device is between about 35 and about 50 mils. It may be even more preferred that the wound care device is between about 38 and about 45 mils. It should be understood, and is exemplified herein, that thickness measurements may be increased when the wound care device also includes an antimicrobial finish on one or more surfaces of the wound care device.

[0054] While potentially preferred fabrics have been described, it is believed that any fiber or fabric that has been treated with the silver-based antimicrobial chemistry described herein is suitable for use within the present wound care device, as well as any of the above-mentioned substrate materials.

Antimicrobial and Other Agents

[0055] The particular treatment used herein comprises at least one silver ion-releasing compound selected from the group consisting of silver ion exchange materials (e.g. zirconium phosphates and zeolites), silver particles (e.g. silver metal, nanosilver, colloidal silver), silver salts (e.g. AgCl, Ag₂CO₃), silver glass, and mixtures thereof. One preferred silver ion-containing compound is an antimicrobial silver sodium hydrogen zirconium phosphate available from Milliken & Company of Spartanburg, South Carolina, sold under the tradename "ALPHASAN®". Other potentially preferred silver-containing antimicrobials suitable for use herein-including silver zeolites, such as a silver ion-loaded zeolite available from Sinanen Co., Ltd. of Tokyo, Japan under the tradename "ZEOMIC®", and silver glass, such as those available from Ishizuka Glass Co., Ltd. of Japan under the tradename "IONPURE®"-may be utilized either in addition to, or as a substitute for, the preferred species listed above. Other silver ion-containing materials may also be used. Various combinations of these silver-containing materials may be made if adjustments to the silver release rate over time are desired.

[0056] Generally, the silver-based compound is added in an amount from about 0.01% to about 60% by total weight of the particular finish composition; more preferably, from about 0.05% to about 40%; and most preferably, from about 0.1% to about 30%. The antimicrobial finish itself, including any desired binders, wetting agents, odor absorbing agents, leveling agents, adherents, thickeners, and the like, is added to the substrate in an amount of at least about 0.01% of the total device weight.

[0057] A binder material has been found useful in preventing the antimicrobial from flaking onto the wound. Preferably, this component is a polyurethane-based binding agent, although a wide variety of cationic, anionic, and non-ionic binders may also be used, either alone or in combination. Preferably, the binding agent is biocompatible such that it does not cause negative reactions in the wound. In essence, such binders provide durability by adhering the antimicrobial to the target substrate, such as fibers or fabrics, without negatively affecting the release of silver ions to the wound.

[0058] Total add-on levels of silver to the target substrate may be 20 ppm or higher. More preferably, total add-on levels of silver may be 200 ppm or higher. Although an upper boundary limit of silver add-on levels to the target substrate has not been determined, consideration of the manufacturing economics and the potential to irritate a sensitive wound site suggests avoiding excessive silver levels.

Application of Antimicrobial and Other Agents to Substrate

[0059] Preferably, silver ion-containing compounds (such as ALPHASAN®, ZEOMIC®, or IONPURE®) are admixed in an aqueous dispersion with a binder to form a bath into which the target substrate is immersed. Other similar types of compounds that provide silver ions may also be utilized.

[0060] When specific polyurethane-based binder materials are utilized, the antimicrobial characteristics of the treated substrate are effective with regard to the amount of surface available silver that is released to kill bacteria, without altering the color of the treated substrate (that is, while substantially maintaining its original appearance). While it currently appears that the use of polyurethane-based binder resins are preferred due to their allowance of silver release and bio-neutral properties, in practice essentially any effective cationic, anionic, or non-ionic binder resin that is not toxic to the wound may be used.

[0061] An acceptable method of providing a durable antimicrobial silver-treated fabric surface is the application of a silver ion-containing compound and polyurethane-based binder resin from a bath mixture. This mixture of antimicrobial

compound and binder resin may be applied through any technique as is known in the art, including spraying, dipping, padding, foaming, printing, and the like. By using one or more of these application techniques, a fabric may be treated with the antimicrobial compound and binder resin on only one side of the fabric (e.g. the wound contact surface of a wound care device), or it may be treated on both sides of the fabric.

[0062] The following examples further illustrate the present antimicrobial device but are not to be construed as limiting the invention as defined in the claims appended hereto. All parts and percents given in these examples are by weight unless otherwise indicated.

Sample Creation and Evaluation

A. Substrate Descriptions

[0063] The fiber used in **Example 1** was a 70 denier 34 filament DACRON® polyester fiber.

[0064] The fabric used in **Examples 2A - 2E** and **Examples 2 Control** was a nonwoven fabric comprised of natural and synthetic fibers. The fabric weight is approximately 68 g/m². The fabric is manufactured and sold by Ahlstrom.

[0065] The fabric used in **Examples 3A - 3B** and **Example 3 Control** was a point-bonded nonwoven fabric, having a fabric weight of 130 g/m² and sold under the tradename EVOLON® by Firma Carl Freudenberg of Weinheim, Germany. Polyester fiber comprised about 65% of the fabric, and nylon 6,6 fiber comprised about 35% of the fabric. The fabric was not dyed.

[0066] The fabric used in **Examples 4A - 4D** and **Example 4 Control** was a nonwoven fabric made of 100% polyester having a weight of approximately 40 g/m². The fabric is sold under the tradename CELFIL® by Polimeros y Derivados. As purchased (prior to addition of an antimicrobial composition), the fabric contained optical brightening agents to enhance the fabric's brightness.

[0067] The fabric used for **Examples 5 - 8** was a jersey knit (circular knit), multi-polymer fabric sold by Milliken & Company. The fabric was single layer of fabric comprised of approximately 66% continuous filament polyamide yarn, 19% continuous filament polyester yarn, and 15% continuous filament spandex yarn. The polyamide yarn was comprised of 2 plies of 40 denier / 34 filament count nylon 6 fiber that was exposed to a texturing process prior to knitting. The polyester yarn was comprised of single ply 70 denier / 34 filament count fiber that was exposed to a texturing process prior to knitting. The spandex yarn was comprised of 55 denier / 3 filament count fiber. The fabric was knitted in such as manner as to give a distinct nylon side and a distinct polyester side. The polyester side of the fabric was exposed to a face-finishing process known as sanding.

B. Antimicrobial Coating Formulations

[0068] Various aqueous dispersions of an antimicrobial finish include combinations of the following components:

- Antimicrobial ALPHASAN® RC2000 silver-based ion exchange compound, available from Milliken & Company of Spartanburg, SC
- Aqueous dispersion of nanosilver particles having an average particle size of between 20nm and 80nm, available from CIMA Nanotech of St. Paul, MN
- WITCOBOND® polyurethane binders available from Chemtura Corporation of Middlebury, CT
- LUBRIL QCJ, a hydrophilic polymer dispersion available from Roebuck Operations of Spartanburg, SC
- FREECAT MX, an aqueous white liquid consisting of a buffered magnesium salt available from Noveon Chemicals of Cleveland, OH

EXAMPLE 1

[0069] A 70-denier, 34 filament DACRON® polyester fiber was used for Example 1. A solution was prepared according to the formulation in TABLE 1 and was applied to the polyester fiber using an Atlab finish applicator manufactured by Atlas Industries. Prior to testing, 12 strands of this fiber were hand twisted into a yarn about 5 cm in length. The resulting fiber had a 7.5% wt/wt content of ALPHASAN® RC2000. The ratio of ALPHASAN® RC 2000 to binder was 1:1.

EP 2 589 393 A2

TABLE 1

Component	Amount (grams)
Water	37
Witcobond W-293 (polyurethane binder; 67% solids)	1.5
AlphaSan® RC 2000 (antimicrobial agent, 10% Ag)	1.5

EXAMPLES 2A - 2E

[0070] The AHLSTROM® nonwoven fabric described above was coated using the formulations shown below in **TABLE 2**. Examples 2A through 2E were prepared using the following steps:

- (a) The coating solution was prepared at room temperature via stirring the components listed below in a container for approximately one hour; and
- (b) the fabric was dipped in a bath, squeezed via nip rollers, and dried in an oven at around 350 °F for between two and three minutes.

[0071] A Control sample (Example 2 Control) was also prepared in a water-only solution, which was exposed to the same process conditions as Examples 2A - 2E.

TABLE 2

Formulations for Examples 2A - 2E							
Sample ID	Components (grams)					% Active AlphaSan® (wt./wt%)	Ratio of AlphaSan® RC 2000 to Binder
	Water	AlphaSan® RC 2000	Witcobond W-293	Lubril QCX	Freecat MX		
Example 2A	365.3	100.0	15.0	9.8	10.0	20.7%	6.6 : 1
Example 2B	409.5	51.2	19.1	10.0	10.2	8.2%	2.7 : 1
Example 2C	417.9	25.0	37.3	9.8	10.0	4.2%	0.67 : 1
Example 2D	398.3	5.1	76.4	10.0	10.0	1.1%	0.067 : 1
Example 2E	477.7	5.0	7.5	9.78	0.08	1.0%	0.67 ; 1
NOTE: The weight/weight % is calculated by dividing the weight of antimicrobial agent as determined by analytical procedure by the weight of the dry coated fabric.							

EXAMPLES 3A - 3B

[0072] The EVOLON® nonwoven fabric described above was coated using the formulations shown below in **TABLE 3**. These Examples were prepared via the same process used to create the finished fabrics of Example 2. A Control sample (Example 3 Control) was also prepared in a water-only solution, which was exposed to the same process conditions as Examples 3A-3B.

TABLE 3

Formulations for Examples 3A - 3B							
	Components (grams)						
Sample ID	Water	AlphaSan® RC 2000	Witcobond W-293	Lubril QCX	Freecat MX	% Active Alphasan® (wt./Wt.%)	Ratio of AlphaSan® RC 2000 to Binder
Example 3A	961.1	444.8	331.7	173.9	88.9	18.2%	1.34 : 1
Example 3B	1740.3	111.2	82.9	43.5	22.2	2.2%	1.34 : 1
NOTE: The weight/weight % is calculated by dividing the weight of antimicrobial agent by the weight of the coated fabric.							

EXAMPLES 4A -4D

[0073] The CELFIL® nonwoven fabric described above was coated using the formulations shown below in TABLE 4. These Examples were prepared via the same process used to create the finished fabrics of Example 2. A Control sample (Example 4 Control) was also prepared in a water-only solution, which was exposed to the same process conditions. The fabric used to create Examples 4A - 4D and Example 4 Control included an optical brightener to enhance its brightness.

TABLE 4

Formulations for Examples 4A - 4D							
	Components (grams)						
Sample ID	Water	AlphaSan® RC 2000	Witcobond W-293	Lubril QCX	Freecat MX	% Active Alphasan® (wt./wt%)	Ratio of AlphaSan® RC 2000 to Binder
Example 4A	1707.1	175.5	65.5	34.3	17.5	16.0%	2.7: 1
Example 4B	456.4	25.0	18.7	0	0	9.9%	1.34: 1
Example 4C	288.4	25.0	186.6	0	0	5.0%	0.13 : 1
Example 4D	457.7	5.0	37.3	0	0	1.2%	0.13 : 1
NOTE: The weight/weight % is calculated by dividing the weight of antimicrobial agent as determined by analytical procedure by the weight of the dry coated fabric.							

EXAMPLES 5A and 5B

[0074] The multi-polymer fabric described above was coated using the formulations shown below in TABLE 5. These Examples were prepared via the same process used to create the finished fabrics of Example 2. In Example 5A, an optical brightener was included as part of the material (before application of the antimicrobial composition). Example 5B did not include an optical brightener.

[0075] Two Control samples (Example 5A Control, which contained an optical brightener, and Example 5B Control, which did not contain an optical brightener) were also prepared in a water-only solution, which was exposed to the same process conditions as Examples 5A and 5B.

[0076] Measurements of the Example fabrics and the Control fabrics were made from both the nylon side of the material and the polyester side of the material.

TABLE 5

Formulations for Examples 5A - 5B						
Sample ID	Components (grams)				% Active Alphasan® (wt./wt%)	Ratio of AlphaSan® RC 2000 to Binder
	Water	AlphaSan® RC 2000	Witcobond W-293	Optical Brightener		
Example 5A	3083.4	705.9	210.7	Yes	14.4	3.35 : 1
Example 5B	2083.4	705.9	210.7	No	20.1	3.35 : 1
The weight/weight % is calculated by dividing the weight of antimicrobial agent as determined by analytical procedure by the weight of the dry coated fabric.						

EXAMPLE 6 - Nanoparticle Silver

[0077] The fabric used in Example 6 was the multi-polymeric fabric of Example 5. This Example was prepared using the same process used to create the fabrics of Example 2. The formulation for this Example is shown in **TABLE 6**. The ratio of nanoparticle silver to binder was 0.66 : 1.

TABLE 6

Nanoparticle Silver Formulation

Component	Amount (Grams)
Water	191
Witcobond 290H (polyurethane binder; 62% solids)	5.3
Cima NanoTech product no. AB120-1 (antimicrobial agent)	3.5

EXAMPLES 7A - 7F

[0078] The fabric used in **Example 7** was the multi-polymeric fabric used in **Example 5**. They were dyed with one of the following pastel dye colors and concentrations.

7A:	Pastel blue color; full dye concentration
7B:	Pastel blue color; half dye concentration
7C:	Pastel green color; full dye concentration
7D:	Pastel green color; half dye concentration
7E:	Pastel purple color; full dye concentration
7F:	Pastel purple color; half dye concentration

[0079] **Examples 7A - 7F** were coated with the same antimicrobial finish (formulation shown in **TABLE 7**). Control samples, corresponding to each of the dyed samples and having the same dye color and amount, were also created and subjected to the same processing conditions. The ratio of ALPHASAN® RC 2000 to binder was 3.33 : 1.

TABLE 7

Formulation used for Examples 7A - 7F

Component	Amount (grams)
Water	1388.1
Witcobond W-293 (polyurethane binder)	141.2
AlphaSan® RC 2000 (antimicrobial agent, 10% Ag)	471.2

EXAMPLE 8A

[0080] A solution was prepared according to the formulation shown below and was applied to the jersey knit fabric of

Example 5 (described previously). The fabric was passed through a bath containing the antimicrobial formulation and subsequently through squeeze rollers to achieve a wet pick-up of about 85%. The fabric was then dried in a tenter frame to remove excess liquid.

[0081] The solution yielded a percent active ALPHASAN® RC 2000 content of 16 weight percent based on the weight of the fabric, as determined by the Total ALPHASAN® RC 2000 Content Test described herein. The ratio of ALPHASAN® RC 2000 to binder was 1.8 : 1.

TABLE 8A

Formulation used for Example 8A

Component	Amount (pounds)
Water	300.0
Witcobond® UCX-281F (polyurethane binder; 40% solids)	52.9
A(phaSan® RC 2000 (antimicrobial agent, 10% Ag)	95.3

EXAMPLE 8B

[0082] A solution was prepared according to the formulation shown below and was applied to the jersey knit fabric of Example 5 (described previously). The fabric was passed through a bath containing the antimicrobial formulation and subsequently through squeeze rollers to achieve a wet pick-up of about 85%. The fabric was then dried in a tenter frame to remove excess liquid.

[0083] The solution yielded a percent active ALPHASAN® RC 2000 content of 17 weight percent based on the weight of the fabric, as determined by the Total ALPHASAN® RC 2000 Content Test described herein. The ratio of ALPHASAN® RC 2000 to binder was 3.35: 1.

TABLE 8B

Formulation used for Example 8B

Component	Amount (pounds)
Water	328.0
Witcobond® 293 (polyurethane binder)	28.0
AlphaSan® RC 2000 (antimicrobial agent, 10% Ag)	94.0

[0084] Each of **Examples 8A** and **8B**, when applied to the jersey knit fabric, result in a wound care device comprising approximately 16% polyester fiber, 53% nylon fiber, 12% spandex fiber, 15% antimicrobial agent, and 4% binding agent.

[0085] Based on the exemplary formulations provided above and the test results provided below, it is contemplated that one preferred embodiment of the present wound care device is a substrate having a non-electrically conductive finish, in which the finish comprises at least one silver ion-releasing compound and at least one binder material, the silver ion-releasing compound being present in an amount that is at least 35% more than the amount of the binder material. The substrate, as mentioned previously, is preferably a fiber, fabric, or alginate, and is most preferably a fabric.

[0086] In an alternate embodiment, which may be preferred for moisture management purposes, a fabric constructed to have a hydrophobic side and a hydrophilic side (such as in Examples 5-8) may be used, in which the hydrophobic side is used as the wound contact side and the hydrophilic side is used as the wound fluid reservoir side. Fluids are drawn through the contact side (away from the wound) and are held in the reservoir side. In this instance, although the presence of a silver ion-releasing compound may be beneficial in promoting wound healing, it is not required.

C. Comparative Sample Descriptions

[0087] Several commercially available silver-containing wound care devices were also purchased for evaluation. These textile-based wound care devices are notated as **Comparative Examples A - M** below and include a wide variety of wound dressing combinations.

[0088] **COMPARATIVE EXAMPLE A** - "ACTISORB® 220", a multi-component nonwoven wound care device comprised of a highly porous, silver impregnated charcoal cloth (containing 220 mg of silver per 100 g of activated charcoal cloth) sandwiched between two nylon nonwoven layers; available from Johnson & Johnson of Somerville, New Jersey.

[0089] **COMPARATIVE EXAMPLE B** - "ACTICOAT® 5", a three layered wound care device consisting of three layers-a layer of polyethylene film, a middle layer of rayon/polyester blend nonwoven fabric, and a second layer of film; nano-crystalline silver particles are deposited onto the film layers; available from Smith and Nephew of Largo, Florida.

[0090] COMPARATIVE EXAMPLE C - "ACTICOAT® 7", a five-layered wound care device consisting of an inner sheet of polyethylene film treated with nano-crystalline silver sandwiched between two layers of untreated rayon fabric; this composite structure is further sandwiched between two layers of polyethylene film treated with nano-crystalline silver; available from Smith and Nephew of Largo, Florida.

[0091] COMPARATIVE EXAMPLE D - "Silverlon", a silver-plated nylon fabric; available from Argentum Medical, LLC of Lakemont, Georgia.

[0092] COMPARATIVE EXAMPLE E - "AQUACEL® Ag", a silver-impregnated sodium carboxymethyl cellulose hydrofiber having 1.2% silver; available from Convatec, a Bristol-Myers-Squibb Company of England.

[0093] COMPARATIVE EXAMPLE F - "AQUACEL®", a hydrofiber dressing; available from Convatec, a Bristol-Myers-Squibb Company of England.

[0094] COMPARATIVE EXAMPLE G - "LYOFOAM®", a sterile, non-adherent, absorbent dressing; available from Convatec, a Bristol-Myers-Squibb Company of England.

[0095] COMPARATIVE EXAMPLE H - "Foam Dressing", a non-adherent foam; available from 3M of St. Paul, Minnesota.

[0096] COMPARATIVE EXAMPLE I - "Woven Gauze Pad", a medical dressing manufactured for Dynarex Corporation of Orangeburg, New York.

[0097] COMPARATIVE EXAMPLE J - "MIRASORB™ Gauze", a nonwoven gauze; available from Ethicon, Inc., a division of Johnson & Johnson of Somerville, New Jersey.

[0098] COMPARATIVE EXAMPLE K - "EVOLON®", a nonwoven fabric comprised of multi-component fibers; the multi-component fibers are comprised of individual nylon and polyester fibers that have been longitudinally split into their individual components by hydroentanglement; the fabric is described in US Patent Nos. 5,899,785 and 5,970,583 both of which are assigned to Firma Carl Freudenberg of Weinheim, Germany and which are incorporated entirely herein by reference. This is the same fabric used in Example 3.

[0099] COMPARATIVE EXAMPLE L - "VERSALON™", nonwoven medical sponges; available from Kendall and trademark of Tyco Healthcare Group LP.

[0100] COMPARATIVE EXAMPLE M - "CONTREET® F", a polyurethane foam having ALPHASAN® RC 2000 silver throughout the polymer matrix; available from Coloplast A/S.

D. Example Testing and Evaluation

[0101] Each of the above examples was tested for a variety of characteristics as will be described below. Further, some of the commercially available products (referred to as Comparative Examples A - M and described above) were also tested for comparison with the present antimicrobial wound care substrates. The testing procedures will be described in detail as follows. However, a listing of the tests used is found below.

- Test 1.** Total ALPHASAN® RC 2000 Content Test (Ashing Technique)
- Test 2.** Zone of Inhibition Test (Kirby-Bauer Agar Diffusion Assay)
- Test 3.** Quantitative Log Reduction Test (Modified AATCC Method 100)
- Test 4.** Wavelength / Reflectance Evaluation
- Test 5.** Whiteness / Yellowness Evaluation
- Test 6.** Color Evaluation: Lightness/Darkness, Yellow/Blue, Red/Green
- Test 7.** Comparison of Magnitude of Color Difference between Sample and Reference Tile
- Test 8.** Color Stability Test
- Test 9.** Fluid Transport Test (Internally developed method)
- Test 10.** Tensile Strength Test (ASTM D 5034)
- Test 11.** Conductivity/Resistivity Test (AATCC Test Method 76)
- Test 12.** Thickness Test (ASTM D 1777-96)

TEST 1 : Total ALPHASAN® Content

[0102] The amount of ALPHASAN® antimicrobial incorporated into or onto an article can be determined by measurement of elements unique to the antimicrobial compound. For ALPHASAN® antimicrobial, the two elements of highest abundance are silver or zirconium. Because zirconium is more abundant in the ALPHASAN® antimicrobial product and is easier to measure, it is preferable to use zirconium as the signature element for determining the level of ALPHASAN® antimicrobial in an article. The amount of ALPHASAN® antimicrobial incorporated into or onto the wound care device was determined using the following ashing technique.

[0103] A sample of fabric (weighing approximately 1 gram but with weight measured to four significant digits) was placed in a clean, dry ceramic crucible which had been weighed. The crucible containing the fabric sample was placed in a muffle furnace whose temperature ramped up at 3 °C/minute to 750 °C. The temperature was then held at 750 °C for four hours. The system was then cooled and the crucible transferred to a desiccator in which it was allowed to reach an equilibrium temperature. The crucible was then weighed. This provides the percent solids of inorganic constituents.

[0104] The fabric sample was then ground in the ceramic crucible to obtain a uniform sample. Approximately 0.05g weight (again measured to four significant digits) was then taken from the ceramic crucible and placed in a platinum crucible. Four milliliters of 50% HNO₃, followed by 15-20 drops of 48% HF, were added to the crucible. The crucible was heated over a hot plate until the sample completely dissolved. The sample solution was then transferred to a 100 mL volumetric flask.

[0105] The crucible was then rinsed with 5% HNO₃, with the rinse solution being added to the flask. The solution was diluted to the 100 mL mark with 5% HNO₃. The dilute solution was transferred to a polyethylene storage container. Analysis for the desired active ingredient (in this case, zirconium) was performed using an Inductively Coupled Plasma Optical Emission Spectrometer device (e.g., a Perkin Elmer Optima 4300DV). Calculations are apparent to one skilled in the art. The amount of ALPHASAN® RC2000 present on the wound care device is provided as a weight percent based on the weight of the fabric. The results are shown in TABLE 9.

TABLE 9

<i>Total ALPHASAN®RC2000 Content of Inventive Wound Care Device</i>	
Sample ID	Percent ALPHASAN® RC2000
Example 1	7.5
Example 2A	20.7
Example 2B	8.2
Example 2C	4.2
Example 2D	1.1
Example 2E	1.0
Example 3A	18.2
Example 3B	2.2
Example 4A	16.0
Example 4B	9.9
Example 4C	5.0
Example 4D	1.2
Example 5A	14.4
Example 5B	20.1
Example 8A	16
Example 8B	17

TEST 2: Zone of Inhibition Test (Kirby-Bauer Agar Diffusion Assay)

[0106] Several Gram-positive and Gram-negative bacteria as well as fungi (yeast) were chosen to illustrate the antimicrobial efficacy of the inventive wound care device. Gram-positive bacteria include, for example and without limitation, *Staphylococcus aureus*, *Clostridium perfringens*, *Enterococcus faecium* and *Bacillus cereus*. Gram-negative bacteria include, for example and without limitation, *Klebsiella pneumoniae*, *Escherichia coli*, *Acinetobacter baumannii*, *Enterobacter cloacae*, *Proteus mirabilis*, and *Pseudomonas aeruginosa*. Fungi, such as yeast, include for example, *Candida albicans* and *Saccharomyces cerevisiae*. Many of these organisms were selected to demonstrate the antimicrobial efficacy of the Examples below. However, it should be understood to be within the scope of this invention that similar results would be obtained against other bacteria and fungi.

[0107] The Zone of Inhibition (ZOI) Test based on the Kirby-Bauer Agar Diffusion Assay provides both a qualitative (level of growth underneath sample) and quantitative (size of zone in millimeters) assessment of the performance of an

antimicrobial agent incorporated into a wound dressing. The level of growth underneath the sample can be rated from confluent ("no activity") to spotty or isolated ("bacteriostatic") to nil ("bactericidal"). If reduced growth is observed underneath the sample for a particular microorganism when compared to an untreated control dressing, that microorganism is considered sensitive and the antimicrobial agent is effective (i.e., is bacteriostatic). The magnitude of the zone of inhibition, if one is observed, is a measure of both the inherent efficacy of the agent and the diffusion of the agent through the nutrient agar matrix. This zone of inhibition assay can be used to measure the efficacy of the dressings in a simulated clinical application by subjecting the dressings to multiple insults of a high level of bacteria over a multiple-day period. For purposes of discussion herein, a substrate is considered to have "effective antimicrobial" properties if it produces a ZOI against bacteria of at least 1 mm after two successive exposures.

[0108] Examples 1 - 5 and Comparative Examples A - E were tested against one or more of *Staphylococcus aureus* ATCC #6538 using a standard zone of inhibition test based on the Kirby-Bauer Agar-Diffusion Assay. The procedure is described in the report "Antibiotic Susceptibility Testing by a Standardized Single Disc Method" written by A.W. Bauer, W.M. Kirby, and M. Truck and published in the American Journal of Clinical Pathology 1966; Volume 45, page 493.

[0109] Examples 1 - 5 and Comparative Examples A - E were tested according to the following procedure. Petri dishes containing Diagnostic Sensitivity Test (DST) agar were inoculated via spreading with 0.5 mL of a diluted overnight culture of approximately 5×10^5 cells/mL of the test organism into 100mM Na/K phosphate buffer. An approximately 1 inch by 1 inch piece of the Example fabric was then placed at the center of each agar plate. The agar plates were incubated for 24 hours at 37 °C, after which the level of efficacy was determined. To simulate repeated exposure of the dressings to microbes, the dressings were removed from the incubated agar plate, placed onto freshly inoculated agar plates, and incubated another 24 hours. This process was repeated for up to 7 days.

[0110] In some cases, an untreated (i.e., without antimicrobial finish) fabric was also tested according to this method. The Control sample was a MEDISPONGE® polyurethane foam available from Lendell, an antimicrobial-free substrate.

[0111] The Zone of Inhibition Test was conducted to determine the antimicrobial activity of the Examples against *Staphylococcus aureus*. The results, which are shown in **TABLE 10**, represent an average of four measurements for each sample (one from each of the four sides of the square sample).

TABLE 10

Antimicrobial Activity of Examples 1-5 and Comparative Examples A-E Against <i>Staphylococcus aureus</i> ATCC #6538 as Determined By Zone of Inhibition Method							
Sample	Average Day 1 Zone (mm)	Average Day 2 Zone (mm)	Average Day 3 Zone (mm)	Average Day 4 Zone (mm)	Average Day 5 Zone (mm)	Average Day 6 Zone (mm)	Average Day 7 Zone (mm)
Example 1	3.0	n/d	n/d	n/d	n/d	n/d	n/d
Example 2A	9	5	7	7	5	5	4
Example 2B	10	6	6	5	2	0	0
Example 2C	9	n/d	5	3	1	0	0
Example 2D	7	1	0	0	0	0	0
Example 2 - Control	0	0	0	0	0	0	0
Example 3A	4	3	3	3	3	2	4
Example 3B	4	3	3	3	2	2	5
Example 3 - Control	0	0	0	0	0	0	0
Example 4A	7	5	4	4	n/d	n/d	n/d
Example 4B	3	3	1	0	n/d	n/d	n/d
Example 4C	0	0	0	0	n/d	n/d	n/d
Example 4D	0	0	0	0	n/d	n/d	n/d
Example 4 - Control	0	0	0	0	0	0	0

(continued)

Antimicrobial Activity of Examples 1-5 and Comparative Examples A-E Against *Staphylococcus aureus* ATCC #6538 as Determined By Zone of Inhibition Method

Sample	Average Day 1 Zone (mm)	Average Day 2 Zone (mm)	Average Day 3 Zone (mm)	Average Day 4 Zone (mm)	Average Day 5 Zone (mm)	Average Day 6 Zone (mm)	Average Day 7 Zone (mm)
Example 5B	5	4	4	4	4	3	4
Example 5 - Control	0	0	0	0	0	0	0
Comparative Ex. A	0	0	0	0	n/d	n/d	n/d
Comparative Ex. B	4	4	4	5	5	4	4
Comparative Ex. C	6	8	7	7	7	5	9
Comparative Ex. D	5	6	5	5	n/d	n/d	n/d
Comparative Ex. E	8	5	6	6	7	4	3
NOTE: "n/d" indicates that the value was not determined.							

[0112] The results demonstrate that the present **Examples 1-5**, all of which contained ALPHASAN® RC 2000, were antimicrobially active against *Staphylococcus aureus*. The control samples, which contained no antimicrobial agent, did not demonstrate antimicrobial activity against any of the bacteria.

[0113] **Example 5B Control, Example 8B, and Comparative Examples C and D** were tested to determine their antimicrobial activity against several microbes using a modified version of the Kirby-Bauer Susceptibility Test. A brief description of the test method is included below. A full description of the test method may be found in the following document: National Committee for Clinical Laboratory Studies (NCCLS) M2-A8: Performance Standards for Antimicrobial Disk Susceptibility Tests; Approved Standard-Eighth Edition; 2003.

[0114] An overnight culture of the test microbe was diluted into saline (0.85% NaCl) to a concentration of 10^6 cells/ml. Petri dishes containing Diagnostic Sensitivity Test (DST) Agar were inoculated with 0.25ml of the cell suspension and incubated for 1 hour. A sample (15 mm diameter circle) of each wound care device was then placed at the center of the agar plate. The agar plate was incubated for 24 hours at 37°C. After measuring the extent of the zones (in mm), the samples were transferred to a fresh DST plate inoculated with the same microbe. The process was repeated for three days (total). The results of the Zone of Inhibition Test for each sample are shown in TABLE 11.

TABLE 11

Zone of Inhibition for Inventive and Comparative Wound Care Devices									
Microbe (ATCC#)	Zone of Inhibition (mm)								
	Example 8B (ALPHASAN® RC 2000)			Comparative Example C (ACTICOAT® 7)			Comparative Example D (SILVERLON®)		
	Day 1	Day 2	Day 3	Day 1	Day 2	Day 3	Day 1	Day 2	Day 3
<i>Acinetobacter baumannii</i> z606)	5.5	5	4	6	5	4	5.5	3.5	0.5
<i>Enterobacter cloacae</i> (#13047)	1.5	1	1	1	1	0.5	1	1	0

(continued)

Zone of Inhibition for Inventive and Comparative Wound Care Devices									
Microbe (ATCC#)	Zone of Inhibition (mm)								
	Example 8B (ALPHASAN® RC 2000)			Comparative Example C (ACTICOAT® 7)			Comparative Example D (SILVERLON®)		
	Day 1	Day 2	Day 3	Day 1	Day 2	Day 3	Day 1	Day 2	Day 3
<i>Enterococcus faecalis</i> (#51299) (VRE)	3.5	2.5	1.5	4.5	3	2	3.5	2.5	1.5
<i>Enterococcus faecium</i> (#19434)	5.5	3.5	6	5.5	3.5	6	6	2	4.5
<i>Escherichia coli</i> (#10536)	4.5	4	2	4.5	4	2.5	4	2	0
<i>Escherichia coli</i> (#8739)	5	4.5	3	nd	nd	nd	nd	nd	nd
<i>Klebsiella pneumoniae</i> (#4352)	5.5	3	3	4.5	3.5	3	5	2	0
<i>Proteus mirabilis</i> (#25933)	5	2	0	4	2.5	2	3.5	0	0
<i>Proteus vulgaris</i> (#8427)	3.5	3	2.5	3	3	3	2.5	1	0
<i>Staphylococcus aureus</i> (#6538)	6	5	3	5	5	4	5	5	4
<i>Staphylococcus aureus</i> (#43300) (MRSA)	4.5	3	2.5	3.5	2.5	2.5	4	2.5	2.5
<i>Staphylococcus epidermidis</i> (#12228)	8	4	3.5	7	4	4	7	2	1
<i>Staphylococcus epidermidis</i> (#51625) (MRSE)	7.3	5.5	4.5	7	6.5	5	7	6	4.5
<i>Candida albicans</i> (#10231)	6	4	4	7	4	4	6	2	0
<i>Saccharomyces cerevisiae</i> (#9763)	4	5	5.5	4	4	1.5	3	1.5	0
nd = not determined									

[0115] The test results in **TABLE 11** illustrate that the inventive wound care device (**Example 8B**) exhibits considerable efficacy against several types of Gram-positive and Gram-negative bacteria, as well as against various fungi (yeast). **Example 5B Control** (no antimicrobial treatment) did not exhibit any efficacy (data not shown).

TEST 3: Quantitative Log Reduction Test (Modified AATCC Method 100)

[0116] **Example 2**, **Example 3**, and **Comparative Examples C** and **E** were tested for antimicrobial performance. Efficacy against bacteria was assessed using a modified version of AATCC Method 100-1999 as described below.

[0117] Portions (approximately 0.5 g) of each fabric were placed in glass vials and exposed to two types of bacteria-*Staphylococcus aureus* ATCC #6538 (0.5 mL of 1.31 E+06 cells/mL) or *Pseudomonas aeruginosa* ATCC #12055

(0.5 ml of 2.63E+05 cells/mL)-each of which was suspended in a solution of 2% Bovine Serum Albumin in 0.85% NaCl for 18 - 22 hours at 37 °C. After incubation, the samples were washed to remove attached cells. The number of viable cells in the wash solution was quantified using a microtiter plate-based "Most Probable Number" assay. The results are shown in TABLE 12. Negative values, as shown for the Control, indicate bacterial growth.

TABLE 12

<i>Efficacy of Antimicrobial Wound Care Devices As Determined By Log Reduction Kill Values</i>		
Sample ID	<i>S. aureus</i>	<i>P. aeruginosa</i>
Example 2A	2.94	n/d
Example 2B	2.57	n/d
Example 2C	1.57	n/d
Example 2D	3.57	n/d
Example 2 - Control	-1.06	n/d
Example 3A	1.36	1.69
Example 3B	2.02	2.21
Example 3 - Control	-0.89	-2.06
Comparative Example C	4.34	4.31
Comparative Example E	0.8	n/d
n/d = not determined		

[0118] Examples 5B Control, Example 8B, and Comparative Examples C and M were tested for antimicrobial efficacy against *Staphylococcus aureus* ATCC #6538. The quantitative reduction of bacteria after exposure to the treated samples versus untreated fabric was assessed using a modified version of AATCC Method 100-1999, "Antibacterial Finishes on Textile Materials: Assessment of." The test procedure is described below.

[0119] Samples (about 40mm in diameter) were placed in sterile 60 ml plastic jars and exposed to bacteria (0.4ml of 10⁵ cells/ml) suspended in (a) simulated wound fluid (prepared as previously described) and 2% Bovine Serum Albumin and (b) simulated wound fluid (prepared as previously described) and 20% Bovine Serum. The jars were tightly capped and incubated for 22 hours at 37°C. The 0.4ml volume was determined to completely wet the wound dressing samples without excess fluid in the container. **Example 3** was inoculated on the polyester side of the wound care device. After incubation for 24 hours at 37°C, the samples were covered with 10ml of Tryptic Soy Broth with surfactants and cysteine to deactivate any residual silver and vortexed to remove attached cells. The number of viable cells in the wash solution was quantified using a microtiter plate-based "Most-Probable Number" assay. The level of viable cells recovered from the treated samples was compared to the number of cells recovered from untreated fabric and the percent reduction calculated. The results are shown in **TABLE 13**.

TABLE 13

<i>Percent Reduction of Inventive and Comparative Wound Care Devices Compared to Untreated Fabric Against Staphylococcus aureus</i>		
Sample ID	Percent Reduction of <i>S. aureus</i> (SWF and 2% Bovine Serum Albumin)	Percent Reduction of <i>S. aureus</i> (SWF and 20% Bovine Serum)
Example 5B Control (no antimicrobial agent)	0.00	0.00
Example 8B (ALPHASAN® RC 2000)	99.96	99.75
Comparative Example C (ACTICOAT® 7)	99.99	99.99
Comparative Example M (CONTREET® F)	94.13	99.69

[0120] The results in **TABLE 13** indicate that over 99% of viable bacteria were reduced after 24 hours of contact with the inventive wound care device (**Example 8B**) compared to similar fabric without the antimicrobial treatment (**Example 5B Control**). For this testing, *Staphylococcus aureus* was selected as the representative microbe. However, it should be understood to be within the scope of this invention that **Example 8B** would exhibit similar antimicrobial efficacy against other Gram-positive and Gram-negative bacteria and against fungi such as *C. albicans*.

EVALUATING COLOR:

PRESENT EXAMPLE DEVICES VS. COMPARATIVE SAMPLES

[0121] As has been previously discussed, providing an essentially white-colored, antimicrobial wound care device is desirable for a number of reasons. First, the antimicrobial properties of the device will facilitate the healing of the wound. This benefit has been described in detail herein. Secondly, by providing an essentially white-colored device, the health care provider and/or user are better able to monitor the exudates from the wound for signs of color change that could indicate a problem.

[0122] The wound care device of the present invention exhibits an unusual whiteness when compared to competitive silver-containing antimicrobial devices. This is, in part, due to the specific silver ion-releasing mechanism of the present finish. As will be discussed herein, the white color of the present wound care device is substantially consistent despite the add-on level of the silver-containing antimicrobial agent and is maintained over its shelf-life. **Examples 2-7**, as well as **Comparative Examples A - E**, were evaluated for color using various measurements, as will be described herein.

TEST 4: Wavelength / Reflectance Evaluation

[0123] **Examples 2A - 2E, 3A - 3B, 4A - 4D, 5A - 5B, 6, and 7A - 7F** were evaluated for color by measuring their reflectance across a given span of wavelengths corresponding to the visible spectrum (i.e., 360 nm - 750 nm). Control samples (i.e., fabrics containing no antimicrobial) for each of the present Examples were also evaluated. This evaluation was accomplished via use of a GretagMacbeth Color Eye 70001 spectrophotometer with a D-65 light source and a 10° observation angle. The **Comparative Examples** were also evaluated, using the same equipment. The reflectance data for **Examples 2 - 5** and the **Comparative Examples** is shown in **TABLES 14-18** below. This data was used to calculate Stensby Index for Whiteness and other comparisons below. Note that a higher reflectance percent indicates a lighter/whiter color.

[0124] It should also be noted that reflectance data, although not shown, was generated for **Examples 6** and **7A - 7F** and serves as the basis for the other color measurements of those Examples as will follow.

TABLE 14

<i>Reflectance of Examples 2A - 2D and Ex. 2 Control</i>					
Wavelength (nm)	Example 2A (20.7%)	Example 2B (8.2%)	Example 2C (4.2%)	Example 2D (1.1%)	Ex.2 Control (0%)
360	62.066	50.841	55.029	48.954	51.407
370	68.091	61.149	62.708	56.198	63.494
380	72.152	67.144	68.933	62.251	70.499
390	75.398	71.047	74.170	67.510	74.569
400	78.111	74.093	77.822	71.604	77.448
410	80.473	76.755	80.397	74.683	79.681
420	82.628	79.207	82.360	77.209	81.532
430	84.419	81.338	83.862	79.293	83.010
440	85.974	83.181	85.157	81.112	84.295
450	87.339	84.760	86.263	82.703	85.451
460	88.563	86.118	87.235	84.135	86.465
470	89.669	87.329	88.118	85.428	87.385
480	90.627	88.389	88.855	86.598	88.172

EP 2 589 393 A2

(continued)

<i>Reflectance of Examples 2A - 2D and Ex. 2 Control</i>					
Wavelength (nm)	Example 2A (20.7%)	Example 2B (8.2%)	Example 2C (4.2%)	Example 2D (1.1%)	Ex.2 Control (0%)
490	91.365	89.216	89.421	87.526	88.785
500	92.090	90.015	89.987	88.436	89.406
510	92.582	90.586	90.391	89.096	89.840
520	92.962	91.029	90.698	89.610	90.192
530	93.273	91.407	90.960	90.053	90.515
540	93.563	91.781	91.242	90.459	90.821
550	93.742	92.034	91.406	90.752	91.010
560	93.909	92.252	91.571	91.029	91.193
570	94.030	92.424	91.694	91.254	91.326
580	94.155	92.584	91.824	91.462	91.472
590	94.270	92.733	91.968	91.648	91.632
600	94.349	92.848	92.082	91.833	91.768
610	94.338	92.869	92.100	91.903	91.812
620	94.439	92.991	92.222	92.065	91.938
630	94.482	93.082	92.304	92.184	92.029
640	94.585	93.212	92.435	92.361	92.175
650	94.608	93.258	92.482	92.442	92.234
660	94.685	93.370	92.590	92.587	92.362
670	94.693	93.390	92.622	92.650	92.421
680	94.699	93.436	92.676	92.712	92.475
690	94.672	93.425	92.684	92.733	92.466
700	94.617	93.405	92.649	92.736	92.465
710	94.595	93.395	92.660	92.731	92.452
720	94.548	93.378	92.636	92.746	92.440
730	94.668	93.492	92.772	92.866	92.552
740	94.762	93.605	92.859	93.002	92.681
750	94.908	93.826	92.966	93.274	92.913

TABLE 15

<i>Reflectance of Examples 3A - 3B and Example 3 Control</i>			
Wavelength (nm)	Example 3A (18.2%)	Example 3B (2.2%)	Example 3 Control (0%)
360	36.197	44.088	46.48
370	50.591	60.687	64.103
380	64.071	72.756	76.585
390	74.915	79.579	83.110
400	81.752	83.286	86.580

EP 2 589 393 A2

(continued)

<i>Reflectance of Examples 3A - 3B and Example 3 Control</i>			
Wavelength (nm)	Example 3A (18.2%)	Example 3B (2.2%)	Example 3 Control (0%)
410	85.343	85.385	88.712
420	87.416	86.731	90.188
430	88.773	87.571	91.196
440	89.879	88.266	92.054
450	90.812	88.865	92.785
460	91.622	89.346	93.400
470	92.349	89.828	93.968
480	92.938	90.225	94.449
490	93.319	90.504	94.758
500	93.750	90.849	95.098
510	94.034	91.084	95.292
520	94.227	91.266	95.440
530	94.405	91.448	95.559
540	94.611	91.649	95.692
550	94.711	91.769	95.751
560	94.821	91.896	95.812
570	94.902	92.013	95.858
580	95.004	92.152	95.926
590	95.089	92.290	95.977
600	95.122	92.398	96.008
610	95.079	92.439	95.946
620	95.159	92.594	96.019
630	95.202	92.705	96.030
640	95.297	92.893	96.123
650	95.328	92.996	96.138
660	95.407	93.133	96.200
670	95.367	93.184	96.163
680	95.386	93.269	96.162
690	95.373	93.306	96.100
700	95.296	93.311	95.989
710	95.290	93.359	95.955
720	95.253	93.386	95.895
730	95.366	93.561	96.014
740	95.480	93.745	96.118
750	95.638	93.981	96.270

TABLE 16

	Reflectance of Examples 4A - 4D and Example 4 Control					
	Wavelength (nm)	Example 4A (16.0%)	Example 4B (9.9%)	Example 4C (5.0%)	Example 4D (1.2%)	Example 4 Control (0%)
5	360	26.958	24.228	18.745	22.122	22.65
	370	27.573	24.349	19.639	22.244	22.639
10	380	27.624	23.949	20.667	21.909	22.143
	390	31.171	27.224	24.934	25.104	25.104
	400	37.445	33.583	31.988	31.377	30.986
	410	55.503	52.738	51.249	50.262	49.482
15	420	88.135	88.755	85.541	85.464	86.578
	430	109.019	112.592	107.557	108.292	112.049
	440	117.182	121.542	115.378	116.723	121.699
20	450	110.478	113.787	108.641	109.135	113.782
	460	102.865	105.017	101.231	100.680	104.566
	470	100.722	102.352	99.020	98.164	101.770
	480	98.470	99.602	96.763	95.621	98.900
25	490	94.931	95.490	93.347	91.809	94.557
	500	93.863	94.154	92.342	90.712	93.110
	510	92.692	92.754	91.226	89.585	91.643
30	520	91.088	90.927	89.723	88.054	89.733
	530	89.835	89.511	88.534	86.897	88.227
	540	89.235	88.793	87.980	86.426	87.476
	550	88.758	88.232	87.516	86.075	86.870
35	560	88.265	87.648	87.040	85.688	86.267
	570	87.857	87.165	86.628	85.348	85.754
	580	87.767	87.032	86.511	85.331	85.601
40	590	87.962	87.203	86.681	85.605	85.774
	600	88.186	87.436	86.902	85.935	86.004
	610	88.247	87.489	86.969	86.055	86.059
	620	88.345	87.564	87.050	86.192	86.126
45	630	88.485	87.713	87.196	86.390	86.259
	640	88.856	88.101	87.583	86.820	86.618
	650	89.229	88.493	87.982	87.267	86.996
50	660	89.630	88.912	88.406	87.722	87.415
	670	89.861	89.117	88.657	87.981	87.632
	680	90.007	89.242	88.819	88.141	87.754
	690	90.065	89.310	88.887	88.236	87.809
55	700	90.066	89.327	88.896	88.277	87.821
	710	90.087	89.341	88.915	88.305	87.836

EP 2 589 393 A2

(continued)

<i>Reflectance of Examples 4A - 4D and Example 4 Control</i>					
Wavelength (nm)	Example 4A (16.0%)	Example 4B (9.9%)	Example 4C (5.0%)	Example 4D (1.2%)	Example 4 Control (0%)
720	90.076	89.337	88.911	88.314	87.827
730	90.184	89.429	88.997	88.424	87.924
740	90.261	89.513	89.054	88.501	87.968
750	90.341	89.682	89.110	88.600	87.987

TABLE 17A

<i>Reflectance of Example 5A and Example 5A Control</i>				
	(Measured through Nylon Side)		(Measured through Polyester side)	
Wavelength (nm)	Example 5A (14.4%)	Example 5A Control (0%)	Example 5A (14.4%)	Example 5A Control (0%)
360	10.80	7.43	21.37	18.89
370	9.041	6.082	24.638	22.082
380	8.722	5.753	26.246	23.578
390	11.341	7.747	28.274	25.351
400	24.935	18.686	36.268	32.439
410	57.559	47.297	56.612	50.811
420	95.044	86.489	83.974	77.617
430	119.201	116.550	104.485	101.018
440	122.047	122.348	108.518	107.630
450	115.143	115.889	104.350	104.276
460	106.568	106.917	98.606	98.605
470	100.533	100.502	94.571	94.513
480	97.432	97.198	92.576	92.554
490	94.413	93.919	90.606	90.494
500	92.877	92.215	89.689	89.511
510	91.403	90.511	88.843	88.550
520	90.295	89.189	88.263	87.839
530	89.560	88.274	87.296	87.372
540	89.197	87.774	87.793	87.111
550	88.955	87.412	87.679	86.899
560	88.820	87.179	87.629	86.774
570	88.827	87.140	87.725	86.805
580	88.860	87.123	87.803	86.836
590	88.935	87.179	87.915	86.929
600	89.114	87.385	88.138	87.175
610	89.251	87.585	88.306	87.416

EP 2 589 393 A2

(continued)

<i>Reflectance of Example 5A and Example 5A Control</i>				
	(Measured through Nylon Side)		(Measured through Polyester side)	
Wavelength (nm)	Example 5A (14.4%)	Example 5A Control (0%)	Example 5A (14.4%)	Example 5A Control (0%)
620	89.504	87.940	88.598	87.792
630	89.810	88.340	88.939	88.222
640	90.234	88.816	89.376	88.734
650	90.551	89.181	89.746	89.121
660	90.904	89.584	90.126	89.561
670	91.219	89.986	90.478	89.975
680	91.483	90.270	90.764	90.285
690	91.750	90.559	91.050	90.588
700	91.886	90.729	91.216	90.777
710	91.971	90.809	91.310	90.884
720	92.014	90.846	91.373	90.940
730	92.025	90.852	91.418	90.956
740	91.960	90.767	91.374	90.886
750	91.847	90.625	91.276	90.739

TABLE 17B

<i>Reflectance of Example 5B and Example 5B Control</i>				
	(Measured through Nylon side)		(Measured through Polyester side)	
Wavelength (nm)	Example 5B (20.1%)	Example 5B Control (0%)	Example 5B (20.1%)	Example 5B Control (0%)
360	48.20	37.37	39.09	33.06
370	59.510	49.121	53.704	46.976
380	66.743	56.887	62.759	55.918
390	71.565	61.994	68.191	61.273
400	75.052	65.964	72.033	65.221
410	77.447	68.948	74.745	68.209
420	79.281	71.376	76.795	70.602
430	80.807	73.465	78.740	72.662
440	82.115	75.283	79.959	74.508
450	83.300	76.950	81.345	76.228
460	84.433	78.532	82.686	77.895
470	85.412	79.930	83.859	79.391
480	86.268	81.181	84.899	80.736
490	86.916	82.140	85.701	81.771
500	87.545	83.042	86.457	82.737

EP 2 589 393 A2

(continued)

Reflectance of Example 5B and Example 5B Control				
	(Measured through Nylon side)		(Measured through Polyester side)	
Wavelength (nm)	Example 5B (20.1%)	Example 5B Control (0%)	Example 5B (20.1%)	Example 5B Control (0%)
510	87.959	83.664	86.976	83.407
520	88.266	84.137	87.361	83.924
530	88.566	84.543	87.733	84.370
540	88.861	84.923	88.095	84.779
550	89.049	85.181	88.337	85.073
560	89.215	85.394	88.552	85.319
570	89.435	85.655	88.817	85.603
580	89.615	85.853	89.051	85.839
590	89.795	86.066	89.272	86.086
600	90.027	86.393	89.543	86.421
610	90.200	86.641	89.749	86.710
620	90.468	86.998	90.045	87.110
630	90.777	87.386	90.402	87.542
640	91.157	87.825	90.819	88.034
650	91.441	88.149	91.137	88.434
660	91.746	88.493	91.474	88.817
670	92.024	88.839	91.784	89.156
680	92.246	89.091	92.033	89.445
690	92.544	89.421	92.351	89.822
700	92.732	89.669	92.562	90.100
710	92.854	89.841	92.703	90.300
720	92.939	89.982	92.808	90.463
730	92.997	90.074	92.876	90.575
740	92.981	90.070	92.858	90.597
750	92.922	89.987	92.796	90.546

TABLE 18

Reflectance of Comparative Examples A - E					
Wavelength (nm)	Comparative Example A	Comparative Example B	Comparative Example C	Comparative Example D	Comparative Example E
360	14.720	19.650	20.716	10.151	33.155
370	23.794	21.652	23.292	10.477	34.267
380	29.113	22.815	25.320	10.525	34.831
390	30.961	23.679	27.120	10.464	35.830
400	31.480	24.275	28.441	10.372	37.109

EP 2 589 393 A2

(continued)

5	Reflectance of Comparative Examples A - E					
	Wavelength (nm)	Comparative Example A	Comparative Example B	Comparative Example C	Comparative Example D	Comparative Example E
10	410	31.630	24.835	29.436	10.257	38.212
	420	31.694	25.182	29.968	10.105	38.758
	430	31.664	24.964	29.706	9.919	38.727
	440	31.600	24.585	29.115	9.745	38.287
	450	31.516	23.989	28.151	9.612	37.669
15	460	31.439	23.446	27.120	9.552	37.066
	470	31.342	23.056	26.191	9.549	36.597
	480	31.253	22.736	25.302	9.626	36.237
	490	31.110	22.432	24.416	9.757	35.878
	500	31.040	22.283	23.712	9.976	35.583
20	510	30.895	22.123	23.033	10.203	35.230
	520	30.769	22.025	22.446	10.491	34.932
	530	30.601	21.937	21.919	10.780	34.645
	540	30.476	21.935	21.533	11.130	34.485
	550	30.302	21.938	21.212	11.472	34.381
25	560	30.153	21.986	20.989	11.844	34.404
	570	29.999	22.072	20.846	12.229	34.551
	580	29.871	22.213	20.798	12.644	34.852
	590	29.716	22.365	20.801	13.048	35.224
	600	29.580	22.580	20.877	13.511	35.754
30	610	29.472	22.822	20.988	13.967	36.322
	620	29.364	23.094	21.122	14.420	36.953
	630	29.223	23.361	21.249	14.853	37.575
	640	29.102	23.684	21.392	15.291	38.239
	650	28.945	24.012	21.520	15.709	38.868
35	660	28.810	24.390	21.663	16.139	39.537
	670	28.659	24.800	21.818	16.565	40.202
	680	28.518	25.262	21.996	16.995	40.899
	690	28.515	25.884	22.323	17.538	41.734
	700	28.527	26.602	22.722	18.110	42.611
40	710	28.468	27.286	23.094	18.611	43.427
	720	28.386	27.986	23.488	19.086	44.216
	730	28.197	28.651	23.866	19.462	44.937
	740	27.907	29.281	24.234	19.758	45.574
	750	27.323	29.804	24.524	19.892	46.068

[0125] The reflectance data from Examples with the highest silver loadings (that is, **Examples 2A, 3A, 4A, and 5B**),

along with the reflectance data from the Comparative Examples, is plotted in line graph in **FIGURE 1**.

[0126] From the data, one observes that the present **Examples** exhibit significantly higher reflectance across the visible spectrum than do any of the **Comparative Examples**. These values are indicative of the white (highly reflective) nature of the present treated articles.

[0127] A review of **FIGURE 1** indicates that **Examples 2A, 3A, 4A, and 5B** are grouped fairly closely together on a line graph, all positioned around the plot of the reflectance data for a white reference tile, where wavelength (in nm) is the x axis and reflectance (%) is the y axis. This indicates that processing conditions have been established to ensure a treated article with a white surface, regardless of the amount of silver-based antimicrobial applied. Even with significant amounts of silver antimicrobial, such as the 20.7% of **Example 2A** and the 20.1 % of **Example 5B**, the color of the treated article is not adversely affected.

[0128] The peak in reflectance values that is observed at wavelengths of between 400 nm and 500 nm in **Example 4A** is due to the presence of an optical brightener. Such brighteners are known to further enhance the reflectivity of an article, but are not required to produce a white color in the present devices.

TEST 5: Whiteness / Yellowness Evaluation

[0129] Whiteness is measured using the Stensby Index for Whiteness. Higher values indicate a fabric with greater whiteness.

[0130] A correlating measure is ASTM E313-73 (D1925), which measures the yellowness of a sample. Higher values indicate a sample with more yellowness; negative values indicate a sample with less yellowness.

[0131] The **Example** fabrics (**2-5**) were measured, as described, with comparison being made to a white reference tile. The white ceramic tile was calibrated and traceable to the National Institute of Standards & Technology (NIST) and is referenced by the (NIST) report, standard reference material 2020c Serial number 27073, 844/259504-98R dated May 14, 1999. The Ceramic Standards are calibrated to the GRETAG MACBETH® Virtual database (STF 19 Sphere). Calibration values displayed are CIELAB 1976, Illuminant D65, and 10° Observer at a controlled temperature of between 71 °F and 73 °F.

[0132] The tests were run using GretagMacbeth Color Eye 7000A spectrophotometer, including a xenon flash light source, with results being provided in **TABLES 19A** and **19B**.

TABLE 19A

<i>Whiteness / Yellowness Measurements: Examples 2 - 4</i>		
Sample Identification	Whiteness (Stensby Index)	Yellowness (ASTM E313-73 (D1925))
White Reference Tile	89.317	9.210
Example 2A	80.622	14.233
Example 2B	77.545	15.456
Example 2C	82.669	13.260
Example 2D	75.450	16.479
Example 2 Control	81.702	13.735
Example 3A	87.117	11.713
Example 3B	88.961	11.040
Example 3 Control	89.985	10.636
Example 4A	128.443	-7.284
Example 4B	135.182	-10.349
Example 4C	126.565	-6.920
Example 4 D	131.201	-8.165
Example 4 Control	136.404	-11.474

TABLE 19B

<i>Whiteness / Yellowness Measurements: Examples 5A and 5B</i>			
Sample Identification	Optical Brightener	Whiteness (Stensby Index)	Yellowness (ASTME313-73 (D1925))
White Reference Tile	n/a	85.799	11.812
Examples 5A (nylon side)	Yes	142.318	-9.885
Example 5A Control (nylon side)	Yes	141.381	-10.773
Example 5A (polyester side)	Yes	121.151	-2.038
Example 5A Control (polyester side)	Yes	118.114	-1.807
Example 5B (nylon side)	No	80.489	14.295
Example 5B Control (nylon side)	No	71.776	17.427
Example 5B (polyester side)	No	77.268	15.762
Example 5B Control (polyester side)	No	70.546	18.172

[0133] The data in TABLES 19A and 19B indicates that, generally, the silver loading does not significantly affect the color of the device. In other words, a manufacturer can apply compositions containing various amounts of silver (and specifically, ALPHASAN® antimicrobial) to a substrate and still maintain a white color in the treated substrate. Heretofore, with other known silver compounds, it has been impossible to obtain a white treated substrate with the effective amounts of silver necessary for wound treatment and infection prevention.

TEST 6: Color Evaluation: Lightness / Darkness, Yellow / Blue, Red / Green

[0134] Often, the surface color of an article is quantified using a series of measurements (L^* , a^* , and b^*) generated by measuring the samples using a spectrophotometer. The equipment used for this test was a GretagMacbeth Color Eye 7000A spectrophotometer. The software program used was "Color imatch." "L" is a measure of the amount of white or black in a sample; higher "L" values indicate a lighter colored sample. "A" is a measure of the amount of red or green in a sample, while "B" is a measure of the amount of blue or yellow in a sample.

[0135] Other measures made using the same testing equipment include C^* and h° . C^* , chroma, is a measure of the color saturation of the article. h° , hue, is a measure of the **shade** of the article.

[0136] TABLES 20A and 20B show a comparison of various samples, as tested by a GretagMacbeth Color Eye 7000A spectrophotometer using the white reference tile described in Test 4 as a standard. It is important to note that the values obtained are dependent upon the type of simulated light source used (e.g., incandescent, fluorescent, etc.) and the angle of observation. In these tests, a D65-10 setting was used (which represents daylight conditions), 6500 °K is the correlated color temperature, and 10° is the angle of observation.

TABLE 20A

<i>Color Measurements of Examples 2 - 4 and Comparative Examples</i>						
Sample ID (% ALPHASAN® Content)	Sample Color	L^*	C^*	h°	a^*	b^*
White reference tile	White	95.587	1.235	114.481	-0.512	1.124
Example 2A (20.7%)	White	97.332	4.382	102.328	-0.936	4.281
Example 2B (8.2%)	White	96.611	5.091	100.910	-0.964	4.999
Example 2C (4.2%)	White	96.433	3.599	100.175	-0.636	3.542
Example 2D (1.1%)	White	96.079	5.636	99.216	-0.903	5.563
Ex. 2 Control (0%)	White	96.255	3.860	99.244	-0.620	3.810

(continued)

Color Measurements of Examples 2 - 4 and Comparative Examples						
Sample ID (% ALPHASAN® Content)	Sample Color	L*	C*	h°	a*	b*
Example 3A (18.2%)	White	97.808	2.721	102.936	-0.609	2.652
Example 3B (2.2%)	White	96.668	2.046	94.481	-0.160	2.040
Ex. 3 Control (0%)	White	98.248	2.051	104.613	-0.517	1.985
Example 4A (16.0%)	White	96.174	8.887	280.515	1.622	-8.738
Example 4B (9.9%)	White	96.060	10.626	280.689	1.971	-10.441
Example 4C (5.0%)	White	95.618	8.621	280.348	1.549	-8.481
Example 4D (1.2%)	White	95.082	9.658	283.814	2.306	-9.379
Ex. 4 Control (0%)	White	95.534	11.162	280.374	2.010	-10.980
Comparative Ex. A	Black interior; white outer layers	61.900	1.898	245.779	-0.779	-1.731
Comparative Ex. B	Dark bluish-gray metallic	54.396	3.595	310.716	2.345	-2.725
Comparative Ex. C	Dark bluish-gray metallic	54.025	9.870	281.791	2.017	-9.662
Comparative Ex. D	Dark gray	40.804	7.903	48.557	5.231	5.925
Comparative Ex. E	Light blue-gray	65.994	3.927	313.587	2.708	-2.845

TABLE 20B

Color Measurements of Examples 5 and 6						
Sample ID (Side on which measurement was made)	% ALPHASAN® Content	L*	C*	h°	a*	b*
White reference tile	n/a	95.513	2.523	95.953	-0.262	2.509
Example 5A (nylon side)	14.4%	96.332	11.471	288.519	3.643	-10.877
Example 5A Control (nylon side)	0%	95.779	11.627	286.509	3.304	-11.147
Example 5A (polyester side)	14.4%	95.518	6.618	290.143	2.279	-6.214
Example 5A Control (polyester side)	0%	95.223	6.142	286.884	1.784	-5.878
Example 5B (nylon side)	20.1%	95.489	4.081	96.754	-0.480	4.053
Example 5B Control (nylon side)	0%	93.771	6.037	97.857	-0.825	5.981
Example 5B (polyester side)	20.1%	95.162	4.969	96.393	-0.553	4.938
Example 5B Control (polyester side)	0%	93.716	6.460	97.150	-0.804	6.410
Example 6 (nylon side)	n/a	67.814	11.041	291.904	4.119	-10.244
Example 6 (polyester side)	n/a	68.382	4.214	291.399	1.537	-3.923

[0137] Looking at the L* values in TABLES 20A and 20B for Examples 2 - 6, it is apparent that there is a slight reduction in L* values as the amount of silver-containing antimicrobial agent (ALPHASAN®) is decreased. As noted, Examples 4A-4D and 5A contain an optical brightening agent, which causes the Examples to emit blue light and which results in the higher h° values shown in TABLES 20A and 20B.

[0138] TABLE 20A shows that the Comparative Examples each have an L* value of less than about 66, indicating the presence of darker shades of color. The present wound care devices have an L* value of at least about 68 (for

instance, when nanoparticle silver is used) and at least about 95 (for instance, when silver ion exchange compounds are used).

[0139] One contemplated benefit of having an antimicrobial wound care device whose color has not been altered by the addition of a silver antimicrobial agent is that the wound care device can be dyed a number of different colors. For example, the wound care devices could be dyed to represent different end uses or levels of antimicrobial agent. Representative colored wound care substrates were prepared as described above. **Examples 7A - 7F** and the corresponding Control samples were measured using the color evaluation techniques and equipment described previously. The results are shown in **TABLES 21A** and **21B**.

TABLE 21A

<i>Color Evaluation: Examples 7A - 7F and Corresponding Control Samples (measured through the nylon side of the fabric with D-65 light source)</i>							
Sample ID	Sample Color	L*	a*	b*	C*	h°	DE CMC
Reference tile	white	95.518	-0.278	2.498	2.513	96.358	n/a
Example 7A	blue	75.609	-11.036	-13.713	17.602	231.173	26.006
Control 7A	blue	72.076	-10.778	-14.562	18.116	233.493	27.052
Example 7B	blue	82.515	-8.789	-9.976	13.295	228.618	20.077
Control 7B	blue	77.970	-9.585	-11.618	15.061	230.475	22.682
Example 7C	green	84.542	-11.911	21.160	24.282	119.375	28.010
Control 7C	green	81.022	-13.322	23.755	27.236	119.285	31.864
Example 7D	green	88.135	-9.642	18.373	20.750	117.690	23.402
Control 7D	green	85.300	-10.861	20.531	23.227	117.880	26.620
Example 7E	purple	74.010	7.616	-12.837	14.541	301.587	23.055
Control 7E	purple	68.487	7.725	-14.171	16.139	298.595	25.660
Example 7F	purple	80.969	5.585	-8.701	10.340	302.697	17.240
Control 7F	purple	75.808	6.527	-10.181	12.094	302.666	19.907

TABLE 21B

<i>Color Evaluation: Examples 7A - 7F and Corresponding Control Samples (measured through the polyester side of the fabric with D-65 light source)</i>							
Sample ID	Sample Color	L*	a*	b*	C*	h°	DE CMC
Reference tile	white	95.518	-0.278	2.498	2.513	96.358	n/a
Example 7A	blue	82.818	-5.967	-7.422	9.523	231.201	15.557
Control 7A	blue	78.653	-5.948	-8.324	10.231	234.454	16.953
Example 7B	blue	85.706	-5.434	-5.993	8.090	227.803	13.444
Control 7B	blue	81.367	-6.069	-7.245	9.451	230.050	15.578
Example 7C	green	87.336	-7.057	12.500	14.354	119.447	15.523
Control 7C	green	84.051	-8.241	13.740	16.008	120.872	17.827
Example 7D	green	89.884	-5.869	10.917	12.395	118.262	12.919
Control 7D	green	87.047	-7.015	12.529	14.359	119.247	15.542

(continued)

<i>Color Evaluation: Examples 7A - 7F and Corresponding Control Samples (measured through the polyester side of the fabric with D-65 light source)</i>							
Sample ID	Sample Color	L*	a*	b*	C*	h°	DE CMC
Example 7E	purple	82.736	3.165	-6.167	6.932	297.169	13.036
Control 7E	purple	77.424	3.566	-7.519	8.321	295.375	15.383
Example 7F	purple	85.972	3.027	-4.732	5.617	302.611	11.006
Control 7F	purple	80.853	3.706	-6.258	7.272	300.633	13.615

[0140] The results shown in **TABLES 21A** and **21B** indicate that the application of the antimicrobial finish described herein does not adversely alter the overall color of the wound care substrate (that is, the DE CMC values are substantially the same between each Example and its Control).

[0141] Further, the Example fabrics exhibited an L* value of at least 74.0, a relatively high level of lightness, which is desirable for wound fluid monitoring purposes.

TEST 7: Comparison of Magnitude of Color Difference between Sample and Reference Tile

[0142] Yet another measurement of the relative color of the samples is DE CMC. DE CMC is a measure of the overall color difference for all uniform color spaces, where DE CMC represents the magnitude of difference between a color and a reference (in this case, a pure white standard). The higher the DE CMC value, the more pronounced the difference in color. Said another way, smaller DE CMC values represent colors that are closer to white.

[0143] The GretagMacbeth Color Eye 7000A Spectrophotometer calculates DE CMC values based on wavelength and reflectance data for each sample. Examples 2A - 2D, 3A - 3B, 4A - 4D, and 5A - 5B were compared to the Comparative Examples. The results are shown in **TABLES 22A** and **22B**.

TABLE 22A

<i>DE CMC: Comparison of Magnitude of Color Difference</i>		
Sample Identification (% active antimicrobial)	L* value (Lightness of sample)	DE CMC
Example 2A (20.7%)	97.332	4.493
Example 2B (8.2%)	96.611	5.465
Example 2C (4.2%)	96.433	3.398
Example 2D (1.1%)	96.079	6.231
Example 2 Control (0%)	96.255	3.765
Example 3A (18.2%)	97.808	2.273
Example 3B (2.2%)	96.668	1.425
Example 3 Control (0%)	98.248	1.511
Example 4A (16.0%)	96.174	14.166
Example 4B (9.9%)	96.060	16.596
Example 4C (5.0%)	95.618	13.791
Example 4D (1.2%)	95.082	15.262
Example 4 Control (0%)	95.534	17.343
Example 5A (14.4%; nylon side)	96.332	18.171
Example 5A Control (0%; nylon side)	95.779	18.387
Example 5A (14.4%; polyester side)	95.518	11.974
Example 5A Control (0%;polyester side)	95.223	11.395

(continued)

<i>DE CMC: Comparison of Magnitude of Color Difference</i>		
Sample Identification (% active antimicrobial)	L* value (Lightness of sample)	DE CMC
Example 5B (20.1%; nylon side)	95.489	1.964
Example 5B Control (0%; nylon side)	93.771	4.472
Example 5B (20.1%; polyester side)	95.162	3.084
Example 5B Control (0%;polyester side)	93.716	5.000

[0144] The data shown in **TABLES 21A, 21B**, and **22A** indicates that the application of the antimicrobial finish described herein does not adversely alter the overall color of the wound care substrate (that is, the DE CMC values of the Example fabrics are approximately equal to or less than the DE CMC values of the respective Control fabrics). This is true whether the sample is dyed (as in **TABLES 21A** and **21B**) or whether the sample is left undyed (i.e., white) (as in **TABLE 22A**).

TABLE 22B

<i>DE CMC: Comparison of Magnitude of Color Difference</i>		
Sample Identification (% active antimicrobial)	L* value (Lightness of sample)	DE CMC
Comparative Example A	61.900	12.244
Comparative Example B	54.396	15.661
Comparative Example C	54.025	21.094
Comparative Example D	40.804	21.519
Comparative Example E	65.994	12.443

[0145] The results shown in **TABLES 22A** and **22B** indicate that, whereas the experimental Examples without optical brighteners exhibited DE CMC value no higher than 6.2, all of the Comparative Examples exhibited a DE CMC value higher than 12. This finding indicates that the Examples prepared in accordance with the teachings herein exhibited less difference from the white standard than did the Comparative Examples.

TEST 8: Color Stability Testing

[0146] It is desirable that the color of the antimicrobial wound care device does not change significantly with the passage of time. With traditional silver-based antimicrobial devices, exposure to light causes a color change in the form of browning or graying. The present device overcomes this shortcoming.

[0147] To evaluate the color durability of the present device, the yellowness of treated Example 2E fabric and untreated Example 2 Control fabric were measured periodically over a 26-day period, using the test method described previously. Both fabrics were subjected to cool-white fluorescent lighting for 24-hour continuous exposure. Five different areas of each sample were evaluated and averaged. The data is reported below in **TABLE 23**.

TABLE 23

<i>Color Durability Testing using Yellowness Index Measure</i>		
Days of Exposure	Control Fabric	Example 2E
0	13.478	13.564
1	13.728	13.716
2	13.547	13.724
3	13.784	13.706
4	13.892	13.700
7	14.020	13.799
8	13.987	13.821

(continued)

<i>Color Durability Testing using Yellowness Index Measure</i>		
Days of Exposure	Control Fabric	Example 2E
11	14.113	13.844
14	14.110	13.715
16	14.201	13.667
18	14.687	14.128
22	14.190	13.664
23	14.188	13.641
24	14.145	13.573
25	14.204	13.757

[0148] The results show that the **Example 2E** performed comparably with the untreated fabric in maintaining its original color over time. There were no visible signs of browning or graying, as are common with silver-containing articles that are exposed to the environment. Rather, **Example 2E** maintained its white appearance throughout the evaluation period.

TEST 9 : Fluid Transport Test

[0149] The purpose of this test is to measure the amount of fluid that is transported from the wound contact side of the wound care device (Side A) to the non-wound contact side of the device (Side B). The test also attempts to measure the amount of fluid pushed back to the wound contact side of the device (Side A).

[0150] Simulated wound fluid ("SWF") was prepared by adding 16.60 g NaCl and 0.56 g CaCl₂ to a 2L volumetric flask. The flask was then filled to volume (2000mL total) with deionized water. The flask was then capped and shaken until all of the salts were completely dissolved. The simulated wound fluid is comprised of 0.142M (142 mM) NaCl (aq) and 0.0025M (2.5 mM) CaCl₂ (aq).

[0151] A test sample of a wound care device (5cm in diameter) was placed onto a polypropylene disc (5cm in diameter). Twenty drops of simulated wound fluid was added to Side A of the test sample using a dropper. The test sample was allowed to rest in a horizontal position for 2 minutes. The test sample was then sandwiched in a vertical position between two discs of filter paper (Whitman filter paper 3, diameter=110mm) using a clamp - Filter Paper A contacted Side A of the test sample and Filter Paper B contacted Side B of the test sample. The test sample was held in this position for 5 seconds. It was determined that the clamp exerts a pressure of 340 mm Hg.

[0152] Filter papers A and B had been weighed prior to the test. They were then weighed after the test and difference in weight was determined. This weight difference provides a calculation of the amount of SWF transferred from the wound care device to Filter Paper A and/or B. The SWF was added to the polyester side ("Side A") of the wound care device of the present invention. SWF was added to the wound contact side of competitive dressings, as directed by the product brochures.

[0153] Test results are shown in **TABLE 24**. The values are provided as "percent weight change." The percent weight change represents the weight of the fluid absorbed relative to the dry weight of the filter paper. It is calculated by subtracting the weight of the dry filter paper (grams) from the weight of the wet filter paper (grams) and dividing this difference by the weight of the dry filter paper. This value is then multiplied by 100. The average percent weight change for Side A and Side B for each Example and Comparative Example was also determined and is provided in **TABLE 24** as well. For instance, the percent weight change values for Side A and Side B for **Example 5B Control**, **Example 8A**, and **Example 8B** were averaged together. The results are shown as 4.8% and 24.2%, respectively. The standard deviation of the average value is also provided.

TABLE 24

Fluid Transport Properties of Inventive and Comparative Wound Care Devices (Provided As Percent Weight Change)

Sample	Side A Fluid	Side B fluid	Average Side A fluid	Standard Deviation	Average Side B fluid	Standard Deviation
Example 5B Control- #1 (no antimicrobial agent)	4.1%	23.4%	4.8%	0.7%	24.2%	0.8%
Example 5B Control- #2	5.3	24.3				
Example 5B Control- #3	5.1	25.0				
Example 8A- #1 (ALPHASAN® RC 2000)	8.2	17.8	9.8	1.8	18.4	0.5
Example 8A- #2	9.3	18.8				0
Example 8A- #3	11.8	18.6				
Comp. Example C- #1 (ACTICOAT® 7)	21.8	8.1	24.6	3.0	11.4	3.1
Comp. Example C- #2	27.7	14.0				
Comp. Example C- #3	24.4	12.2				
Comp. Example D- #1 (SILVERLON®)	5.5	6.0	6.2	0.6	2.2	3.3
Comp. Example D- #2	6.8	0.1				
Comp. Example D- #3	6.3	0.7				
Comp. Example E- #1 (AQUACEL® Ag)	2.6	2.0	2.3	0.2	1.8	0.2
Comp. Example E- #2	2.2	1.5				
Comp. Example E- #3	2.1	1.8				
Comp. Example F- #1 (AQUACEL®)	1.6	0.0	1.3	0.4	0.0	0.0
Comp. Example F- #2	1.5	0.0				
Comp. Example F- #3	0.9	0.0				

(continued)

	Sample	Side A Fluid	Side B fluid	Average Side A fluid	Standard Deviation	Average Side B fluid	Standard Deviation
5	Comp. Example G-#1 (LYOFOAM®)	23.2	12.7	27.3	3.9	10.2	2.5
	Comp. Example G-#2	30.9	10.0				
10	Comp. Example G-#3	27.9	7.8				
	Comp. Example H-#1 (Foam Dressing)	20.5	0.0	22.9	2.2	0.0	0.0
15	Comp. Example H-#2	23.6	0.1				0
	Comp. Example H-#3	24.7	0.1				
20	Comp. Example I-#1 (Woven Gauze Pad)	18.1	17.8	19.4	2.2	16.5	1.4
	Comp. Example I-#2	18.2	16.6				
25	Comp. Example I-#3	21.9	15.1				
	Comp. Example J-#1 (MIRASORB™ Gauze)	31.0	1.6	29.4	2.1	2.3	1.0
30	Comp. Example J-#2	27.0	1.8				
	Comp. Example J-#3	30.1	3.5				
35	Comp. Example K-#1 (EVOLON®)	14.0	11.6	13.0	1.4	12.2	2.0
	Comp. Example K-#2	13.6	10.6				
40	Comp. Example K-#3	11.4	14.5				
	Comp. Example M-#1 (CONTREET® F)	18.8	0.0	18.3	0.7	0.0	0.0
45	Comp. Example M-#2	17.6	0.0				
50	Comp. Example M-#3	18.5	0.0				

[0154] The results shown in **TABLE 24** demonstrate that the inventive wound care device provide significant movement of fluid away from the wound contact side of the device (Side A) to the reservoir side of the device (Side B). This directional fluid movement occurs even under pressure exerted from both sides of the wound care device. The results further show that the fluid movement is generally uni-directional in that the reservoir side (Side B) collects and holds most of the fluid and keeps it from flowing back to the wound contact side of the device (Side A).

[0155] These features are exhibited by the present device, whether or not the device also contains an antimicrobial

agent.

[0156] It was also noted during this test that both of the AQUACEL® wound care devices fell apart. They were not able to hold together structurally after absorbing the SWF.

TEST 10: Tensile Strength Test

[0157] Tensile strength (grab) of various wound care devices was determined using ASTM D 5034. The purpose of this test is to determine structural integrity of wet and dry wound care devices. The devices were wetted by dipping them in simulated wound fluid (same formulation as described previously). The test results are provided in **TABLE 25**. Measurements are shown in pounds of force (lbf). Higher values indicate that more force was needed to tear the sample.

TABLE 25

<i>Tensile Strength of Inventive and Comparative Wound Care Devices</i>			
Sample ID	Sample Condition	Average of All Peaks (lbf)	Average of All Peaks (lbf)
Sample	Dry/Wet	Mean	Standard Deviation
Example 5B Control (no antimicrobial agent)	Dry	3.848	0.004
Example 5B Control (no antimicrobial agent)	Wet	5.106	0.216
Example 8B (ALPHASAN® RC 2000)	Dry	3.827	0.357
Example 8B (ALPHASAN® RC 2000)	Wet	4.561	0.300
Comparative Example F (AQUACEL®)	Dry	3.089	0.130
Comparative Example F (AQUACEL®)	Wet	Sample fell apart when wetted. Test was not done.	Sample fell apart when wetted. Test was not done.
Comparative Example G (LYOFOAM®)	Dry	1.163	0.012
Comparative Example G (LYOFOAM®)	Wet	1.013	0.014
Comparative Example L (VERSALON™)	Dry	0.563	0.030
Comparative Example L (VERSALON™)	Wet	0.595	0.133

TEST 11: Conductivity/Resistivity Test

[0158] The purpose of this test is to determine the conductivity and resistivity (R) of the inventive wound care device. The test was performed according to AATCC Test Method 76.

[0159] The test results are shown in **TABLE 26**. Each value is an average of four measurements. Log R also includes the standard deviation.

TABLE 26

<i>Conductivity and Resistivity of Inventive Wound Care Device</i>			
Sample ID	Conductivity (amperes)	Resistivity (ohms/sq.)	Log R (ohms/sq.)
Example 5B Control (no antimicrobial)	4.204E-11	2.147E+12	12.33 +/- 0.06
Example 8A (ALPHASAN® RC 2000)	3.958E-11	2.238E+12	12.34 +/- 0.07

[0160] The detection range of the testing equipment is in the range of 12 - 13 for the Log R value. Both **Example 5B Control** and **Example 8A** are below the detection limit of the testing equipment. Thus, the inventive wound care device is non-electrically conductive.

TEST 92 : Thickness Test

[0161] The purpose of this test was to measure the thickness of the inventive wound care device. The test was performed according to ASTM D 1777-96. The results are provided as an average with the standard deviation of ten measurements for each sample. The results are shown in **TABLE 27**.

TABLE 27

<i>Thickness of Inventive Wound Care Device</i>	
Sample ID	Average Thickness (mils)
Example 5B Control (no antimicrobial)	40.75 +/- 0.40
Example 8B (ALPHASAN® RC 2000)	42.20 +/- 0.25

[0162] As described previously, any of the substrates described herein may be used alone as a wound care device, including fabrics and alginates. Additionally, one or more of these substrates may be joined together in any possible combination to form a composite, multi-layered, wound care device. The layers may be joined together through various techniques such as ultrasonic welding, heat or pressure lamination, the use of adhesives, needle punching, hydraulic needling, sewing, or other fiber and/or fabric layer laminating or joining processes known to those skilled in the art. The layers may be joined together only at intermittent locations or the layers may be joined together completely.

[0163] The topical antimicrobial finish of the current invention may be applied to any one or more of the substrate layers comprising the composite wound care device. Additionally, an odor absorbing agent or layer (such as activated carbon) may be included on or within one or more layers of the composite wound care device. Furthermore, in some instances, the wound care device may have an adhesive layer so that the device may be held in place over the wound site. In such cases, a layer of removable film may be placed over the wound-facing side of the wound care device to protect the adhesive layer until ready for use. Alternatively, the wound care device may be held in place by wrapping long pieces of wound dressing, such as gauze, over and around the wound care device and securing the free end in place by any suitable means, such as tape, adhesive, pins, clips, or hooks.

[0164] Thus, the above description and examples show that a topical antimicrobial finish may be applied to a variety of substrates to achieve an antimicrobially effective, silver-containing wound care device having the desired characteristics of antimicrobial efficacy, functional release of silver, absence of a dark color, and fluid transport. As has been described herein, the present wound care device possesses a significant advantage over competitive products, in that it exhibits a white color uncharacteristic of silver-containing antimicrobial articles, in that the white color is sustainable over long periods (i.e., in production, transit, and storage), and in that it possesses unique fluid transport properties.

[0165] These and other modifications and variations to the present invention may be practiced by those of ordinary skill in the art, without departing from the spirit and scope of the present invention. Furthermore, those of ordinary skill in the art will appreciate that the foregoing description is by way of example only, and is not intended to limit the scope of the invention described in the appended claims.

[0166] The present invention in particular pertains to the following subject-matter:

1. A wound care device having a substrate selected from the group consisting of fibers, fabrics, and alginates, at least a portion of said substrate being coated with a non-electrically conductive finish, wherein said finish comprises at least one silver ion-releasing compound and at least one binder material, and wherein said silver ion-releasing compound is present in an amount that is at least 35% more than the amount of said binder material.

2. The wound care device of item 1, wherein said at least one silver ion-releasing compound is selected from the group consisting of silver ion exchange materials, silver particles, silver nanoparticles, silver salts, silver glass, and mixtures thereof.

3. The wound care device of item 2, wherein said silver ion-releasing compound is a silver ion exchange material selected from the group consisting of silver zirconium phosphate, silver calcium phosphate, silver zeolite, and mixtures thereof.

4. The wound care device of item 3, wherein said silver ion exchange material is silver zirconium phosphate.
5. The wound care device of item 1, wherein said substrate onto which said finish is applied is a fabric.
- 5 6. The wound care device of item 5, wherein said substrate is a woven fabric.
7. The wound care device of item 5, wherein said substrate is a nonwoven fabric.
8. The wound care device of item 5, wherein said substrate is a knit fabric.
- 10 9. The wound care device of item 8, wherein said knit fabric is a circular knit fabric comprised of polyester and nylon, such that said knit fabric has a polyester side and a nylon side.
10. The wound care device of item 9, wherein said knit fabric further comprises an elastomeric yarn.
- 15 11. The wound care device of item 1, wherein said binder material is a polyurethane-based material.
12. The wound care device of item 1, wherein said device exhibits effective antimicrobial properties, as defined by a zone of inhibition against bacteria of at least 1 mm after two successive exposures.
- 20 13. The wound care device of item 1, wherein said wound care device exhibits an L* value, before use, of at least 68.0, when measured between wavelengths of 360 nm and 750 nm using a D65 light source and a 10° observation angle.
- 25 14. A wound care device having a substrate selected from the group consisting of fibers, fabrics, and alginates, at least a portion of said substrate being coated with a non-electrically conductive finish, wherein said finish consists essentially of at least one silver ion-releasing compound and at least one binder material, wherein said coated wound care device exhibits a first DE CMC value, and
- 30 wherein an uncoated substrate to which said finish has not been applied exhibits a second DE CMC value, and wherein said first DE CMC value is approximately equal to or less than said second DE CMC value.
15. The wound care device of item 14, wherein said substrate is a fabric.
- 35 16. The wound care device of item 15, wherein said coated wound care device is dyed.
17. The wound care device of item 15, wherein said coated wound care device is printed.
18. The wound care device of item 14, wherein said silver ion-releasing compound is silver zirconium phosphate.
- 40 19. The use of a silver-releasing wound care device for monitoring treatment of a wound site, said wound care device having an L* value of at least 68.0, said use comprising the steps of:
 - 45 (a) providing the wound care device of item 14;
 - (b) applying said wound care device to a wound site; and
 - (c) monitoring the various stages of healing at the wound site.
20. A wound care device comprising:
 - 50 a fabric having a wound contact surface and a wound fluid reservoir surface, wherein said wound contact surface is comprised primarily of hydrophobic fiber and said wound fluid reservoir surface is comprised primarily of hydrophilic fiber, said hydrophobic and hydrophilic fibers being intermeshed together; and
 - 55 wherein said wound care device transports wound fluid uni-directionally from said wound contact surface to said wound fluid reservoir surface upon exposure to a wound.
21. The wound care device of item 20, wherein at least said wound contact surface is coated with a composition comprising at least one compound that releases silver ions.

22. The wound care device of item 21, wherein said device is non-electrically conductive.
23. The wound care device of item 20, wherein said hydrophobic and hydrophilic fibers are intermeshed together in a knit fabric construction.
24. The wound care device of item 20, wherein said knit fabric construction is a jersey knit.
25. The wound care device of item 20, wherein said hydrophobic fiber is polyester fiber.
26. The wound care device of item 20, wherein said hydrophilic fiber is polyamide fiber.
27. The wound care device of item 24, wherein said device further comprises an elastomeric fiber.
28. The wound care device of item 20, wherein said hydrophobic and hydrophilic fibers are intermeshed together in a woven construction.
29. The wound care device of item 20, wherein said hydrophobic and hydrophilic fibers are intermeshed together in a nonwoven construction.
30. The wound care device of item 20, wherein said at least one compound releasing silver ions is selected from the group consisting of silver ion exchange materials, silver particles, silver salts, silver glass, and mixtures thereof.
31. The wound care device of item 30, wherein said silver ion exchange material is selected from the group consisting of silver zirconium phosphate, silver calcium phosphate, silver zeolite, and mixtures thereof.
32. The wound care device of item 31, wherein said silver ion exchange material is silver zirconium phosphate.
33. The wound care device of item 20, wherein said composition further comprises a binding agent selected from the group consisting of polyurethane binders, acrylic binders, and mixtures thereof.
34. The wound care device of item 33, wherein said binding agent is a polyurethane-based material.
35. The wound care device of item 20, wherein said fluid reservoir surface is coated with a composition comprising at least one compound delivering silver ions.
36. The wound care device of item 35, wherein said device exhibits effective antimicrobial properties, as defined by a zone of inhibition against bacteria on Diagnostic Sensitivity Test Agar of at least 1 mm after two successive exposures.
37. The wound care device of item 35, wherein said device is non-electrically conductive.
38. The use of a wound care device for managing the movement of wound fluid from a wound site to said wound care device, said wound care device having a wound contact surface and a wound fluid reservoir surface, said use comprising the steps of:
 - (a) providing the wound care device of item 20;
 - (b) applying said wound care device to a wound site, such that said wound contact surface of said wound care device is contiguous with said wound site; and
 - (c) managing the movement of wound fluid by uni-directionally transporting said wound fluid through said wound contact surface to said wound fluid reservoir surface.

Claims

1. A wound care device having a substrate selected from the group consisting of fibers, fabrics, and alginates, at least a portion of said substrate being coated with a non-electrically conductive finish, wherein said finish comprises at least one silver ion-releasing compound and at least one binding agent, and wherein said silver ion-releasing compound is present in an amount that is at least 35% more than the amount of

said binding agent.

2. The wound care device of Claim 1, wherein said substrate onto which said finish is applied is a fabric.

5 3. The wound care device of Claim 2, wherein said fabric is a circular knit fabric comprised of polyester and nylon, such that said knit fabric has a polyester side and a nylon side.

10 4. The wound care device of Claim 1, wherein said wound care device exhibits an L* value, before use, of at least 68.0, when measured between wavelengths of 360 nm and 750 nm using a D65 light source and a 10° observation angle.

15 5. The wound care device of Claim 2, wherein said coated wound care device exhibits a first DE CMC value, and wherein an uncoated substrate to which said finish has not been applied exhibits a second DE CMC value, and wherein said first DE CMC value is approximately equal to or less than said second DE CMC value.

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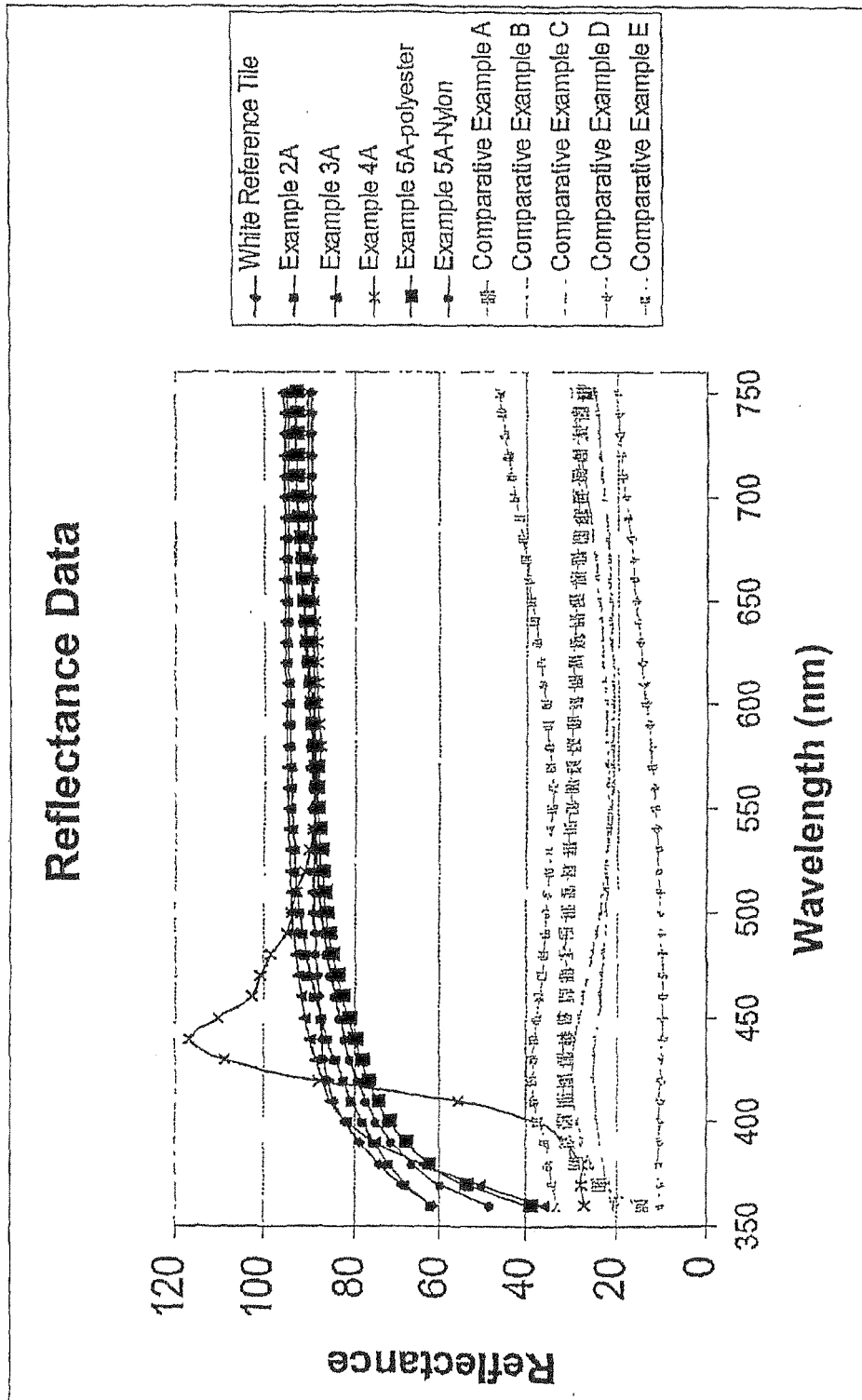


FIGURE 1

REFERENCES CITED IN THE DESCRIPTION

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